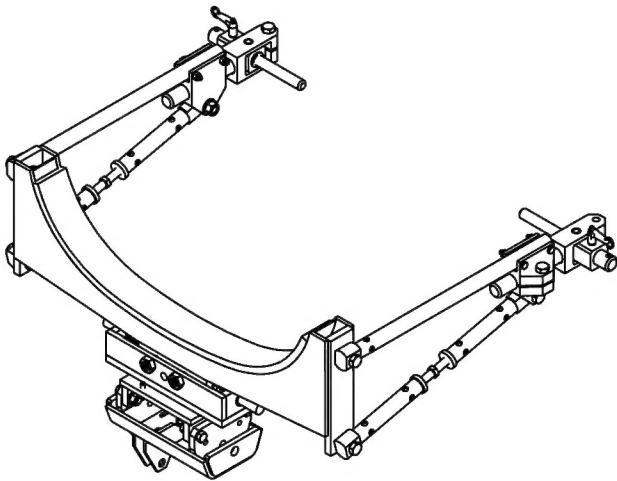


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	5/1/2017	SM	JAG
B	ECR 74	UPDATE DIMENSION ON -283 PER ECR 74; REMOVED REVISIONS BLOCK FROM SHEET 2 TO SHEET 29	2/3/2021	SAD	SAO

ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
									X		-141	1	BOX WELDMENT		RB T102012-141	1
								X			-163	1	CUP WELDMENT		RB T102012-163	1
											-173	1	CRADLE ROD	4140 G&P	RB T102012-173	1
											-179	1	FLANGE BEARING	BRONZE	RB T102012-179	1
											-181	2	PIVOT BRACKET	A36/1018/1020 HR	RB T102012-181	1
										B/O	-193	4	HEX HEAD CAP SCREW	STEEL	5/16-18 X 1 (MCMASTER-CARR #92865A583)	1
										B/O	-195	4	HEX NUT	STEEL	5/16-18 (MCMASTER-CARR #95462A030)	1
										B/O	-197	4	WASHER	STEEL	Ø5/16 (MCMASTER-CARR #95229A450)	1
										B/O	-201	4	HEX NUT	STEEL	7/16-20 (MCMASTER-CARR #95462A520)	1
										B/O	-203	4	WASHER	STEEL	Ø7/16 (MCMASTER-CARR #90126A032)	1
										B/O	-209	2	SLOTTED SPRING PIN	STEEL	Ø1/4 X 3/4 (MCMASTER-CARR #90692A740)	1
										B/O	-211	1	SLOTTED HEX NUT	STEEL	1-1/4 -12 (MCMASTER-CARR #95030A360)	1
										B/O	-213	1	THRUST CAGE ASSEMBLY	STEEL	2-3/4 O.D. (MCMASTER-CARR #5909K43)	1
										B/O	-215	2	THRUST WASHER	STEEL	Ø2-3/4 O.D. (MCMASTER-CARR #5909K56)	1
										B/O	-217	4	HEX NUT	STEEL	5/8-11 (MCMASTER-CARR #94846A533)	1
										B/O	-219	4	BALL-NOSE SPRING PLUNGER	STEEL	5/8-11 X .984 (MCMASTER-CARR #3408A124)	1
										B/O	-221	2	COMPRESSION SPRING	STEEL	Ø.105 X Ø.97 O.D. X 3-1/2 (MCMASTER-CARR #9657K455)	1
										B/O	-223	1	SLOTTED SPRING PIN	STEEL	Ø1/4 X 2 (MCMASTER-CARR #90692A749)	1
										B/O	-225	2	FLANGE BEARING	BRONZE	SYMCO #SF-2432-10	1
										B/O	-231	1	COTTER PIN	STEEL	Ø3/16 X 3 (MCMASTER-CARR #98338A290)	1
							X				-235	1	REAR CRADLE WELDMENT			3
							1				-237		REAR CRADLE TOP	A36/1018/1020 HR		4
							2				-239		REAR CRADLE SIDE	A36/1018/1020 HR		5
						X					-241	1	AFT CRADLE WELDMENT			6
						2					-243		AFT CRADLE PLATE	A36/1018/1020 HR		7
						2					-245		AFT CRADLE SIDE PLATE	A36/1018/1020 HR		8
						1					-247		AFT CRADLE PIVOT	A36/1018/1020 HR		9
						1					-249		AFT CRADLE FACE	A36/1018/1020 HR		10
						2					-251		AFT CRADLE BOTTOM PLATE	A36/1018/1020 HR		11
					X						-253	2	TOP TUBE WELDMENT			12
					1						-255		TOP TUBE	DOM		13
					1						-257		MOUNT PIN	A36/1018/1020 HR		14
					X						-259	2	LOWER AFT TUBE WELDMENT			15
					1	1					-261		LOWER TUBE AFT	DOM		16
					1						-263		LOWER TUBE PIN	A36/1018/1020 HR		17
					1						-265		LOWER TUBE MOUNT PIN AFT	A36/1018/1020 HR		18
			X								-267	2	LOWER FORWARD TUBE WELDMENT			19
			1								-269		LOWER TUBE LH PIN	A36/1018/1020 HR		20
	X										-271	2	AFT ADJUSTABLE CLAMP ASSEMBLY			21
	1										-273	1	AFT CLAMP WELDMENT			22
	1										-275		CLAMP	A36/1018/1020 HR		23
	1										-277		CLAMP PIN	4140/4142		24
										B/O	-279	2	DOWEL PIN	STEEL	Ø1/2 X 1/2 (MCMASTER-CARR #98381A708)	21
											-281	1	BLOCK	A36/1018/1020 HR		25
											-283	1	BLOCK PIN	4140/4142		26
											-285	2	ADJUSTABLE CONNECTOR	4140/4142		27
											-287	2	TOP TUBE CLAMP	A36/1018/1020 HR		28
										B/O	-289	4	HEX HEAD CAP SCREW	STEEL	7/16-20 X 1-1/2 (MCMASTER-CARR #92865A316)	1
-273 ASSY	-271 ASSY	-267 ASSY	-257 ASSY	-253 ASSY	-241 ASSY	-235 ASSY	-163 ASSY	-141 ASSY								

ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
										B/O	-291	8	HEX HEAD CAP SCREW	STEEL	1/2-20 X 2 (MCMASTER-CARR #91257A748)	1
										B/O	-293	6	WASHER	STEEL	Ø1/2 I.D. (MCMASTER-CARR #90126A033)	1
										B/O	-295	6	HEX NUT	STEEL	1/2-20 (MCMASTER-CARR #94895A825)	1
										B/O	-297	4	HEX HEAD CAP SCREW	STEEL	1/4-28 X 2 (MCMASTER-CARR #91257A568)	1
										B/O	-299	4	NYLON INSERT HEX LOCKNUT	STEEL	1/4-28 (MCMASTER-CARR #97135A215)	1
										B/O	-301	2	HEX HEAD CAP SCREW	STEEL	1/2-20 X 1-1/4 (MCMASTER-CARR #92620A745)	1
										B/O	-303	2	QUICK-RELEASE PIN	STEEL	Ø1/4 X 1-1/2 (MCMASTER-CARR #90302A113)	1
											-305	1	REAR CRADLE PAD	17124	1/2 X 2-1/2 X 29-1/8	29
										B/O	-307	4	FERRULE	ALUMINUM	Ø1/16 X 3/8 (MCMASTER-CARR #3896T31)	1
										B/O	-309	2	LANYARD	COATED STEEL	Ø1/16 X 12 (CARR LANE #CL2C)	1
-273 ASSY	-271 ASSY	-267 ASSY	-257 ASSY	-253 ASSY	-241 ASSY	-235 ASSY	-163 ASSY	-141 ASSY								

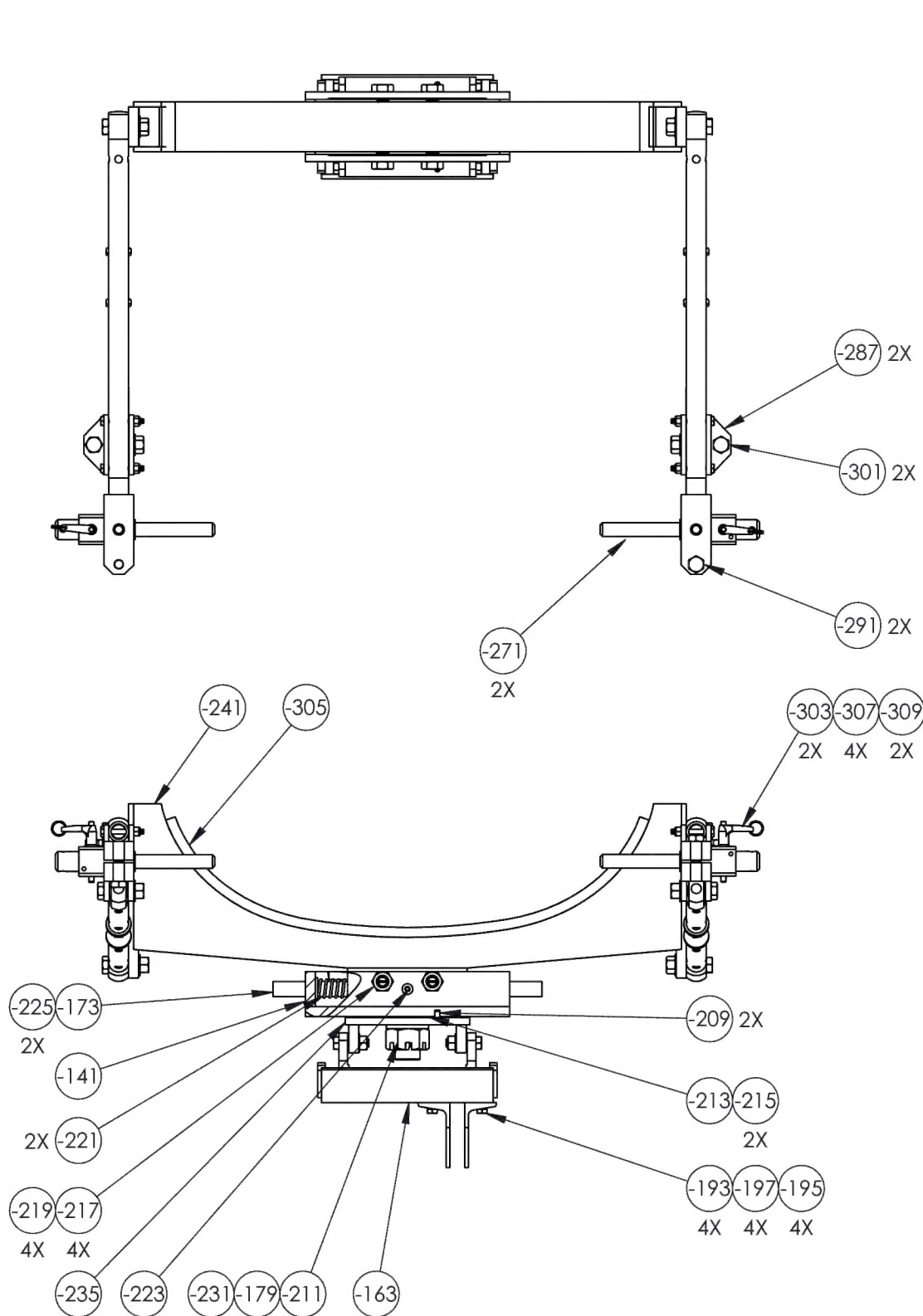


-17

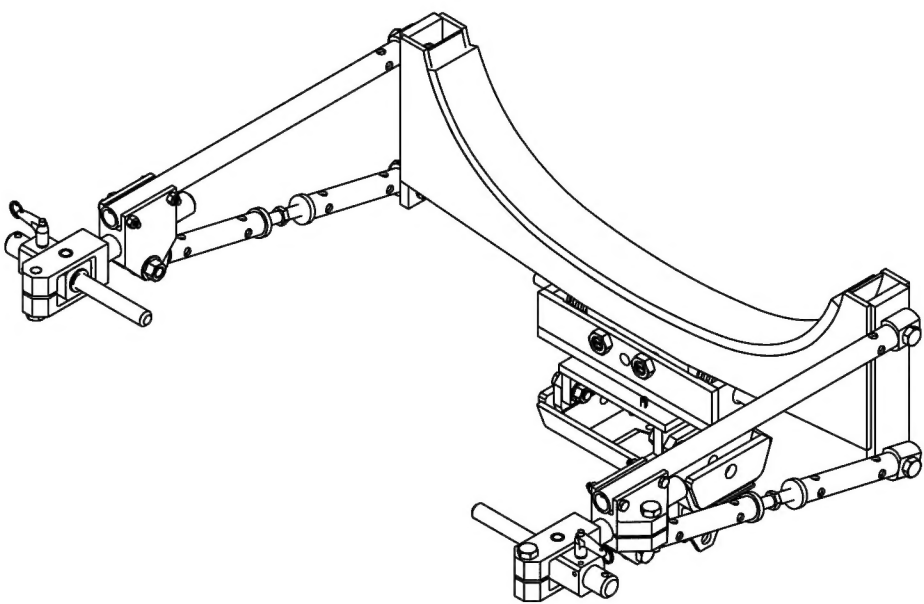
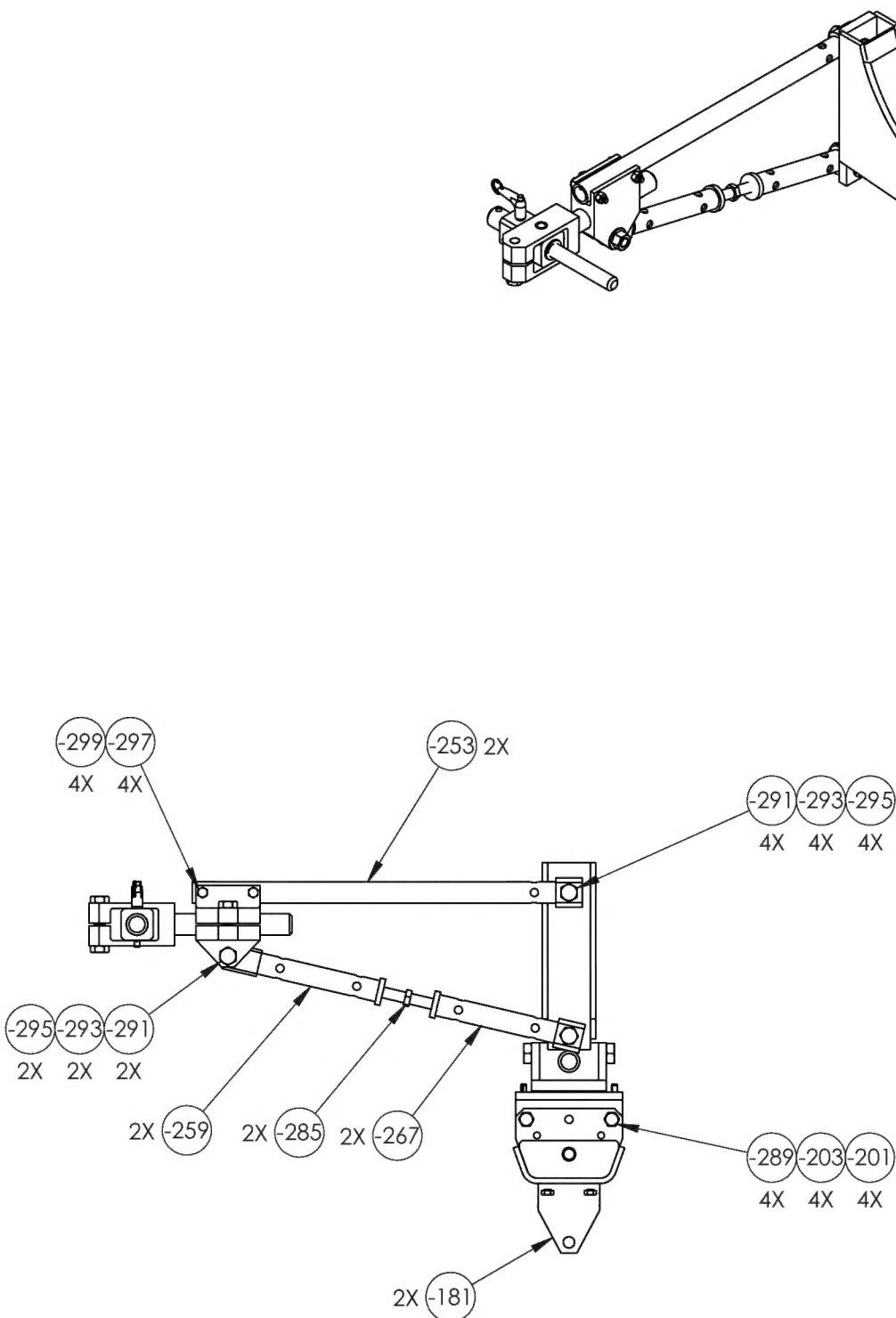
REAR LIFT ASSEMBLY

TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-17	REV B
MAT'L HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ±.5° .X ± .1 SURFACES = 125	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL	
DRAWN BY: GILBERT	
CHECKED: RF	
OPPS APPR: FK	
QA APPR: N/A	
APPROVED: SAD	BELL 212, 214B, 214ST, 412
SCALE 1:12	DATE 3/13/2014 SHEET 1 OF 29

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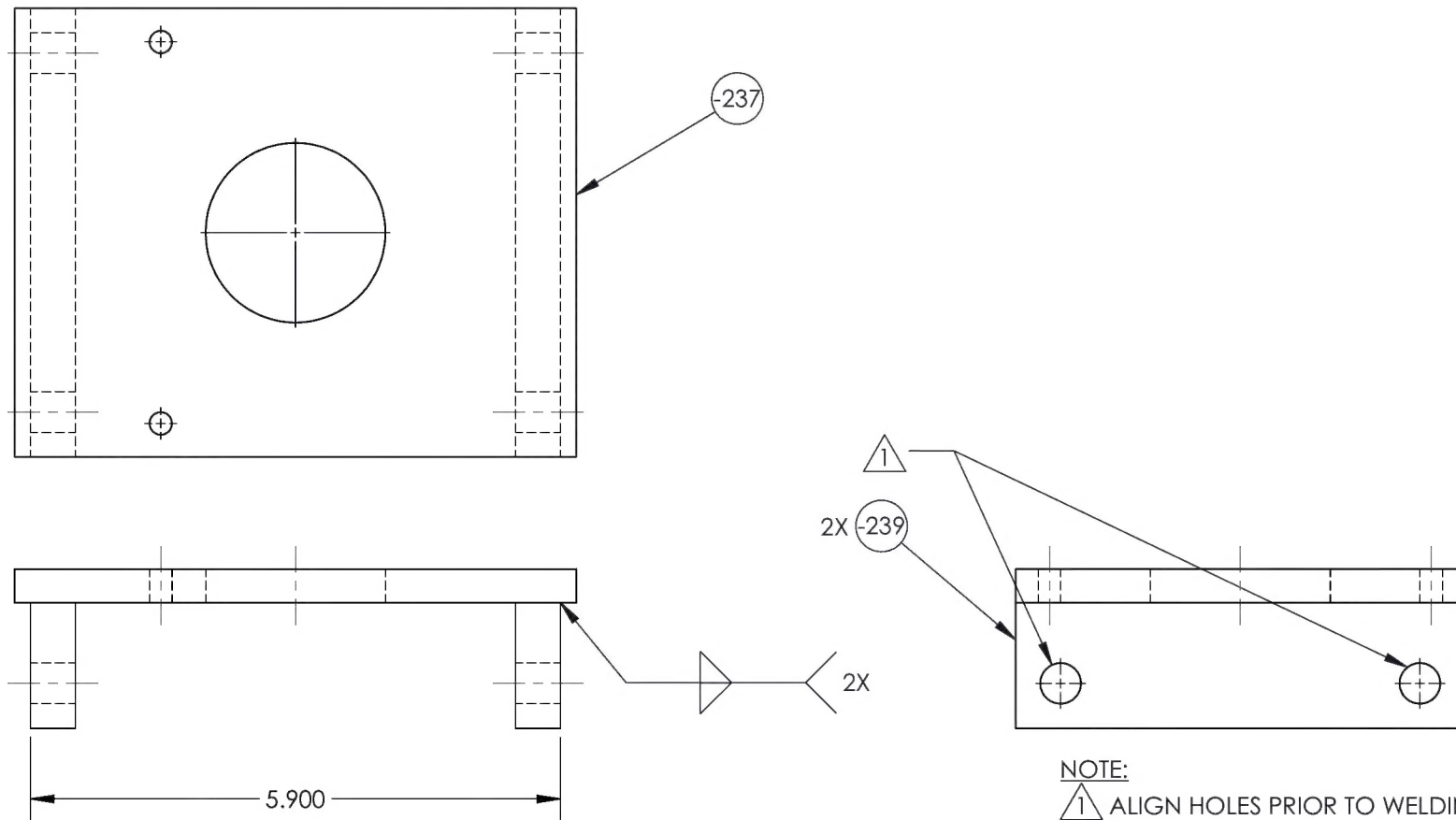


-17
REAR LIFT ASSEMBLY



DART AEROSPACE			
TITLE SUPPORT DOLLY, TAILBOOM			REV B
DWG NO. RB T102012-17			
MAT'L		UNLESS OTHERWISE SPECIFIED	
HEAT		DIMENSIONS ARE IN INCHES	
TREAT		.XXX ± .005 FRACTIONS ± 1/8	
FINISH		.XX ± .01 ANGLES ± .5°	
SPEC		.X ± .1 SURFACES = 125	
DRAWN BY: GILBERT		1. BREAK ALL SHARP EDGES	
CHECKED: RF		.015 x 45° OR .015R	
OPPS APPR: FK		2. DIMENSIONAL LIMITS APPLY	
QA APPR: N/A		AFTER PLATING	
APPROVED: SAD		3. INTERPRET DIM AND TOL PER	
SCALE 1:8		ASME Y14.5M-2009	
DATE 3/13/2014		USED ON MODEL	
SHEET 2 OF 29		BELL 212, 214B, 214ST, 412	

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NOTE:

1 ALIGN HOLES PRIOR TO WELDING.

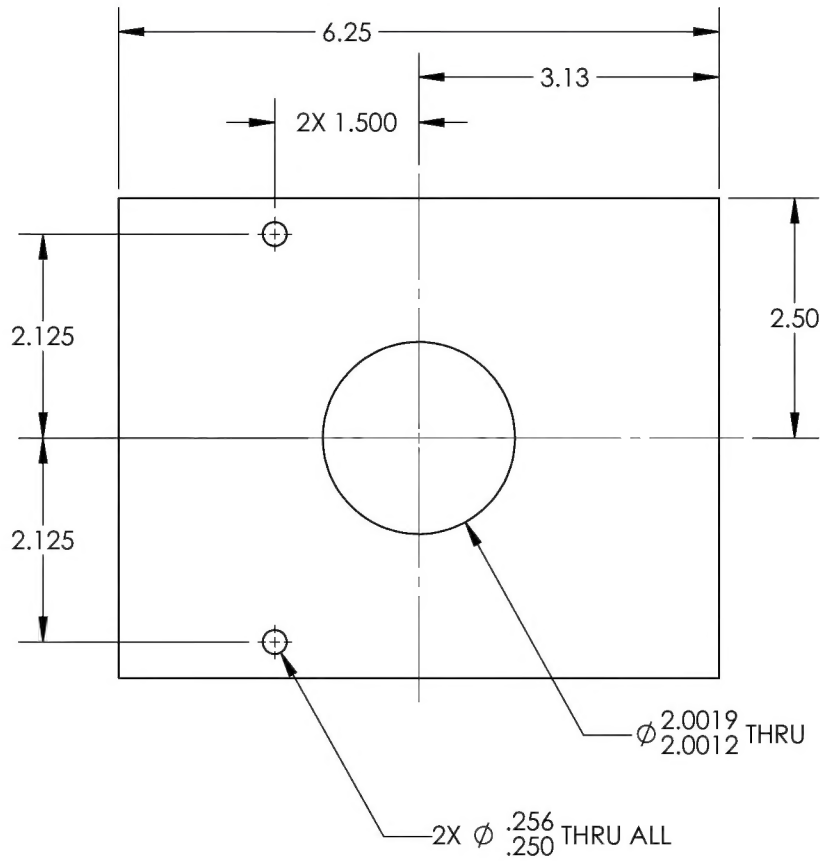
-235

REAR CRADLE WELDMENT



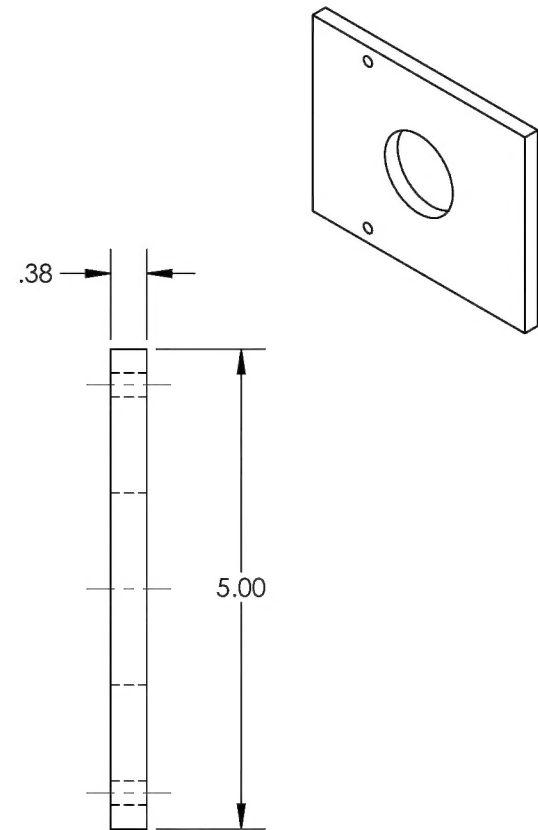
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DWG NO.		RB T102012-235	
REV		B	
MAT'L		UNLESS OTHERWISE SPECIFIED	
HEAT		DIMENSIONS ARE IN INCHES	
TREAT		.XXX ± .010 FRACTIONS ± 1/8	
FINISH		.XX ± .03 ANGLES ± 1°	
POWDER COAT YELLOW		.X ± .1 SURFACES = 125	
SPEC		FED #13538	
DRAWN BY:		GILBERT	
CHECKED:		RF	
OPPS APPR:		FK	
QA APPR:		N/A	
APPROVED:		SAD	
SCALE		1:2	
DATE		3/13/2014	
SHEET		3 OF 29	

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(-237)

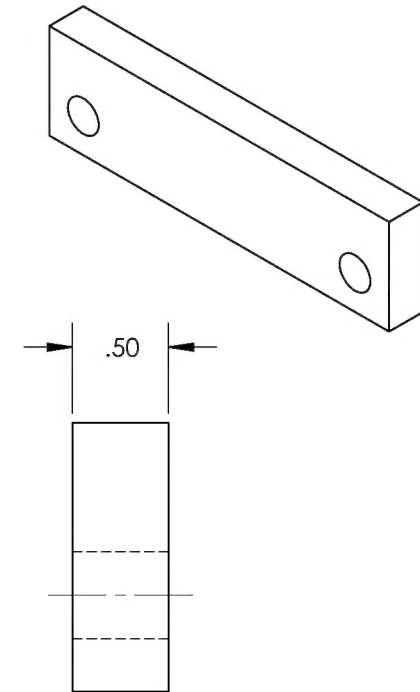
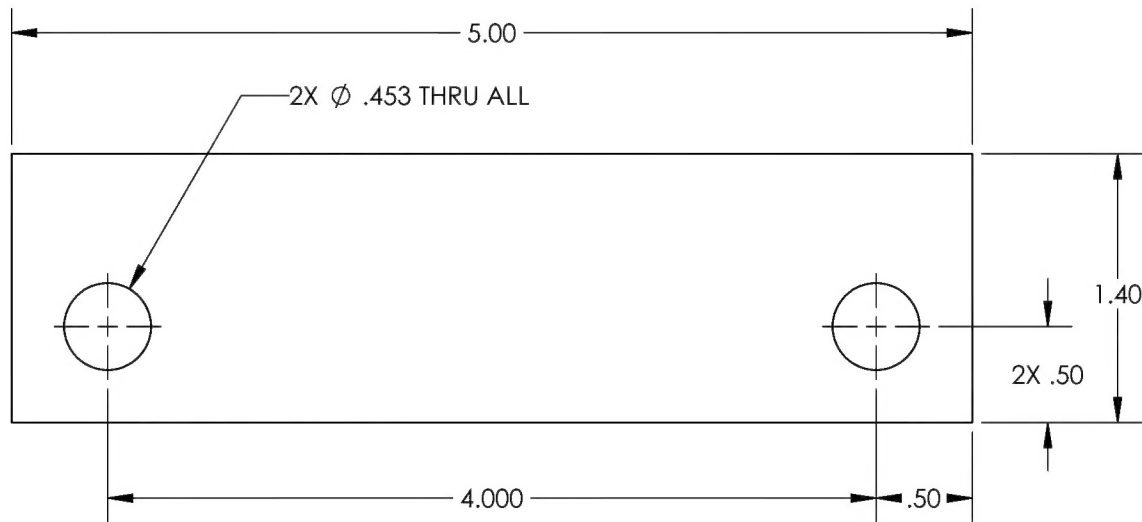
REAR CRADLE TOP



DART
AEROSPACE

TITLE		SUPPORT DOLLY, TAILBOOM	
DWG NO.		RB T102012-237	
REV		B	
MAT'L A36/1018/1020 HR		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH SEE -235 WELDMENT		.XXX \pm .010 FRACTIONS \pm 1/8	
SPEC		.XX \pm .03 ANGLES \pm 1°	
DRAWN BY: GILBERT		.X \pm .1 SURFACES = 125°	
CHECKED: RF		1. BREAK ALL SHARP EDGES	
OPPS APPR: FK		.015 x 45° OR .015R	
QA APPR: N/A		2. DIMENSIONAL LIMITS APPLY	
APPROVED: SAD		AFTER PLATING	
SCALE 1:2		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE 3/13/2014		USED ON MODEL	
SHEET 4 OF 29		BELL 212, 214B, 214ST, 412	

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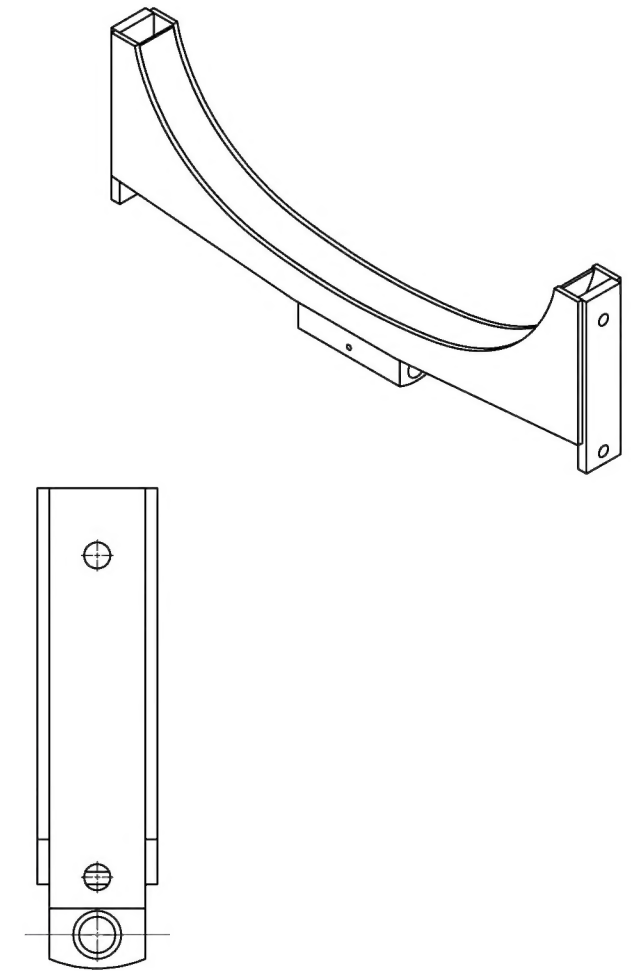
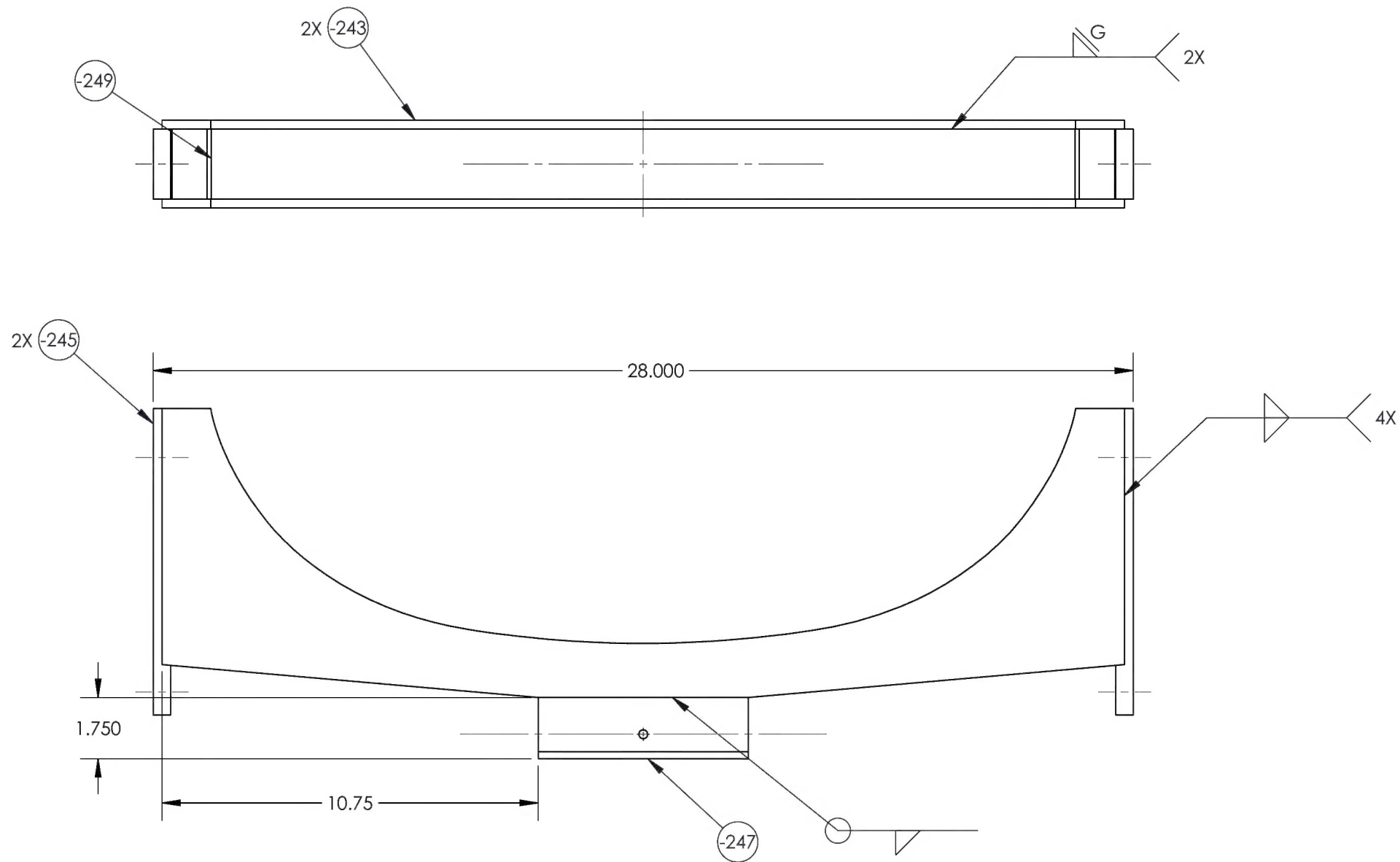
(-239)

REAR CRADLE SIDE



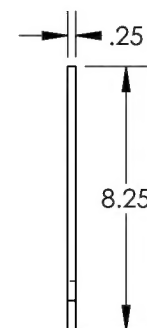
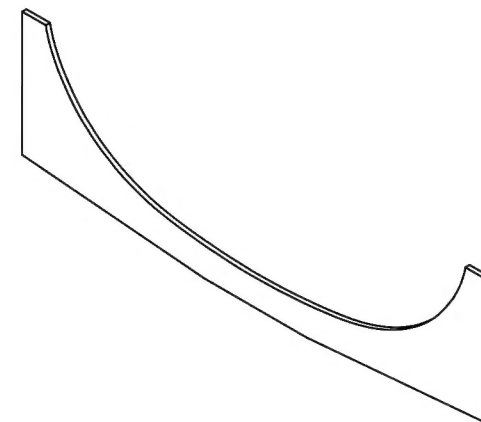
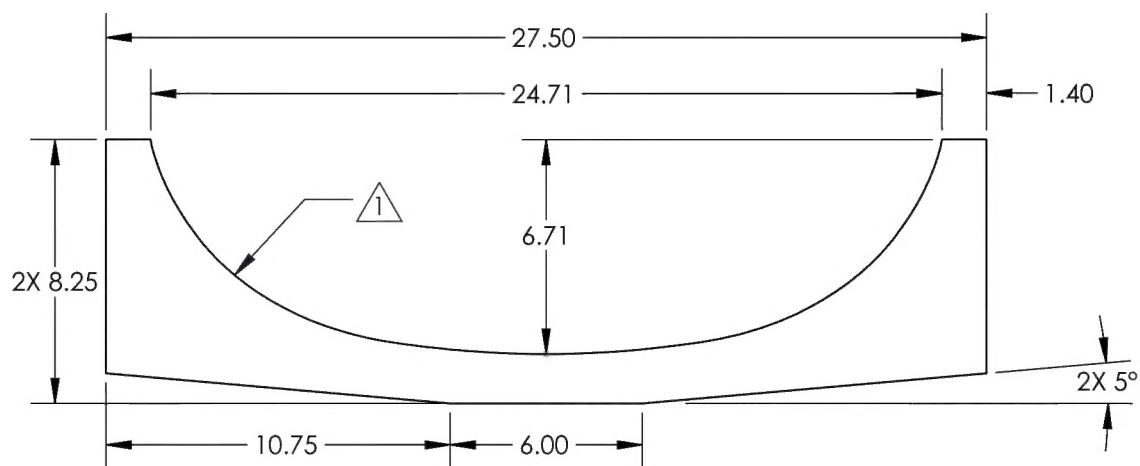
TITLE		SUPPORT DOLLY, TAILBOOM	
DWG NO.		RB T102012-239	
		REV B	
MAT'L A36/1018/1020 HR		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH SEE -235 WELDMENT		.XXX ± .005 FRACTIONS ± 1/8	
SPEC		.XX ± .01 ANGLES ± .5°	
DRAWN BY: GILBERT		.X ± .1 SURFACES = 125	
CHECKED: RF		1. BREAK ALL SHARP EDGES	
OPPS APPR: FK		.015 x 45° OR .015R	
QA APPR: N/A		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
APPROVED: SAD		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
SCALE 1:1		USED ON MODEL	
DATE 3/13/2014		BELL 212, 214B, 214ST, 412	
		SHEET 5 OF 29	

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DART AEROSPACE			
TITLE SUPPORT DOLLY, TAILBOOM			
DWG NO. RB T102012-241			REV B
MAT'L HEAT TREAT FINISH POWDER COAT YELLOW SPEC FED #13538		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125	
DRAWN BY: GILBERT		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED: RF		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR: FK		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR: N/A		USED ON MODEL	
APPROVED: SAD		BELL 212, 214B, 214ST, 412	
SCALE 1:4	DATE 3/13/2014	SHEET 6 OF 29	

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NOTES:

1 USE CAD DATA FOR MANUFACTURE.

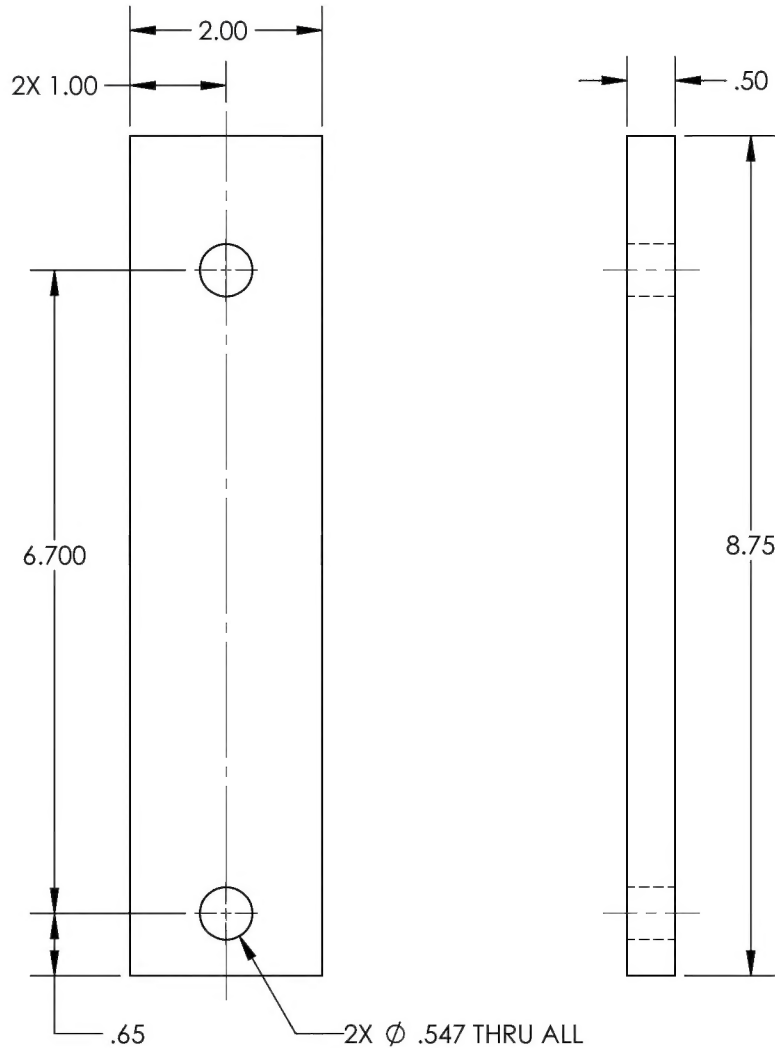


TITLE		SUPPORT DOLLY, TAILBOOM	
DWG NO.		RB T102012-243	
REV		B	
MAT'L		A36/1018/1020 HR	
HEAT TREAT		SEE -241 WELDMENT	
SPEC		UNLESS OTHERWISE SPECIFIED	
DRAWN BY:		GILBERT	
CHECKED:		RF	
OPPS APPR:		FK	
QA APPR:		N/A	
APPROVED:		SAD	
SCALE		1:6	
DATE		3/13/2014	
SHEET		7 OF 29	

-243

AFT CRADLE PLATE

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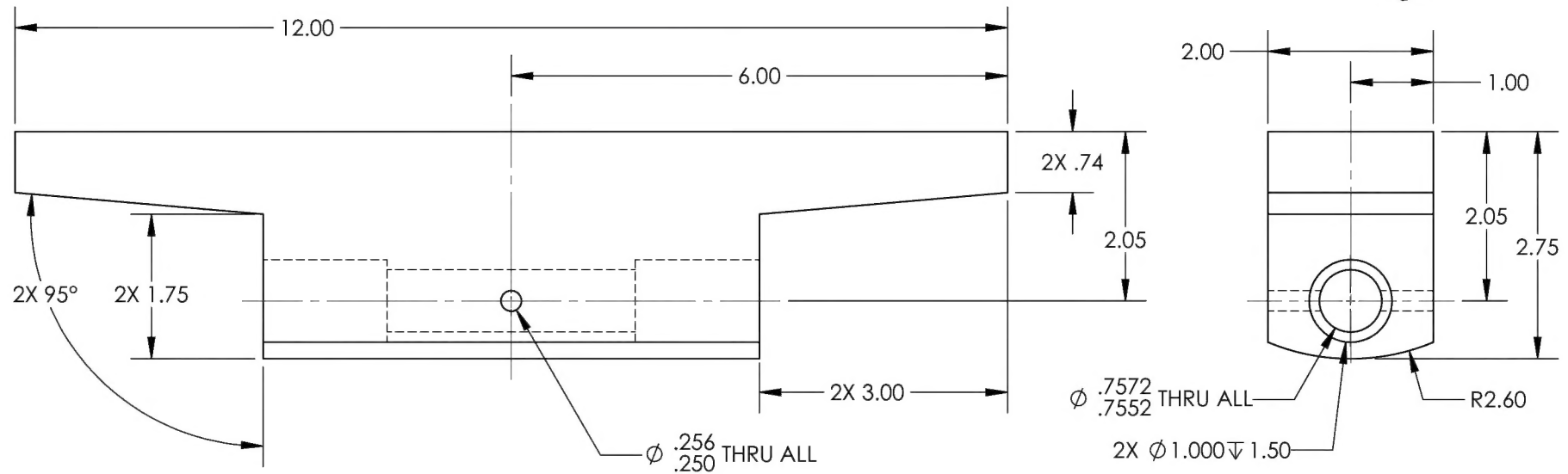
(-245)

AFT CRADLE SIDE PLATE



DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-245	REV B
MAT'L A36/1018/1020 HR HEAT TREAT FINISH SEE -241 WELDMENT SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: GILBERT CHECKED: RF OPPTS APPR: FK QA APPR: N/A APPROVED: SAD	
USED ON MODEL BELL 212, 214B, 214ST, 412	
SCALE 1:2	DATE 3/13/2014
SHEET 8 OF 29	

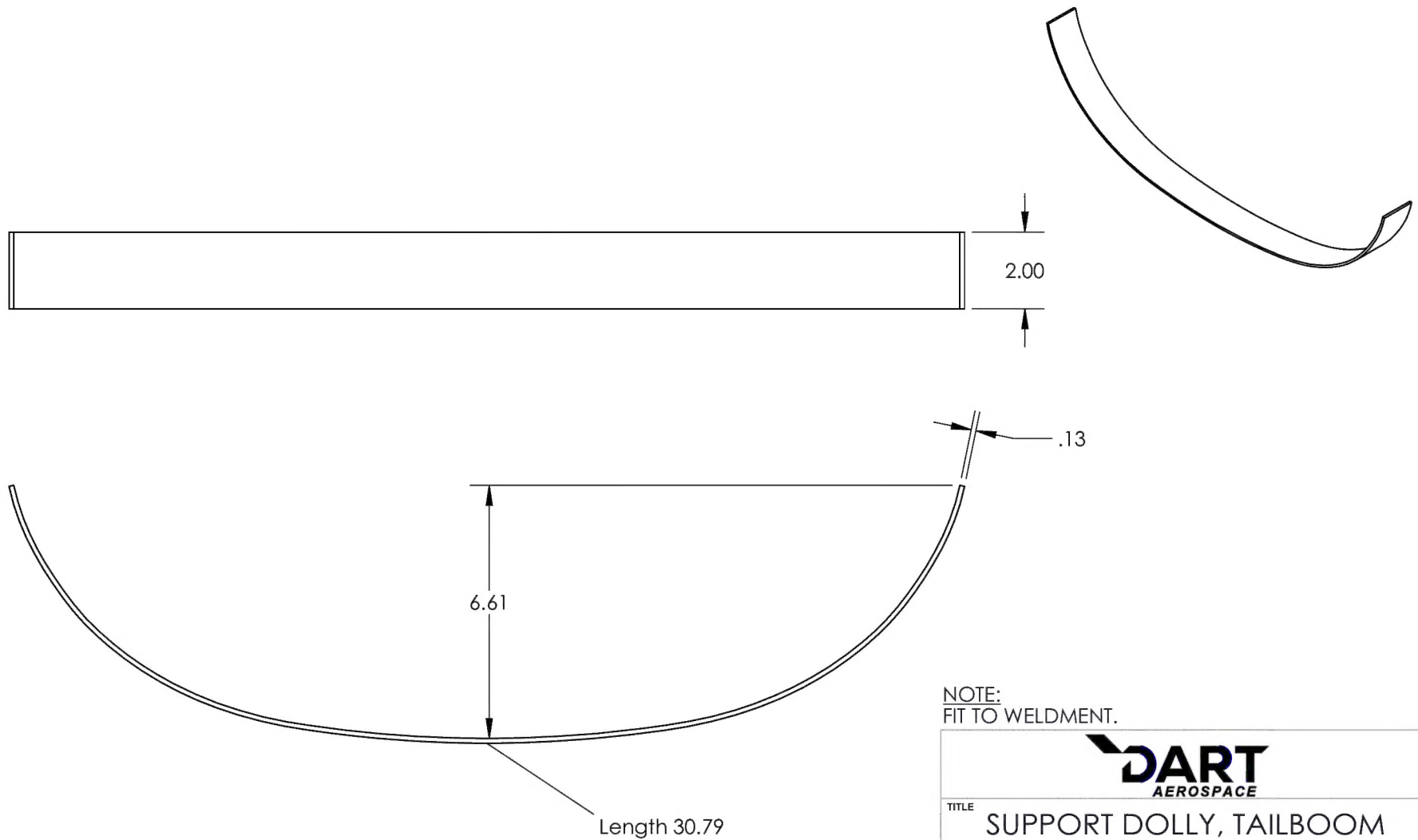
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(-247)
AFT CRADLE PIVOT

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-247	REV B
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -241 WELDMENT	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: RF	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: FK	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: N/A	USED ON MODEL
APPROVED: SAD	BELL 212, 214B, 214ST, 412
SCALE 1:2	DATE 3/13/2014
SHEET 9 OF 29	

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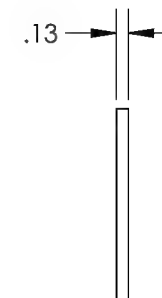
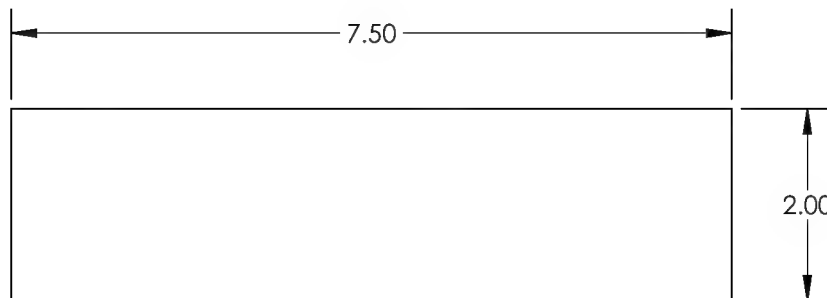
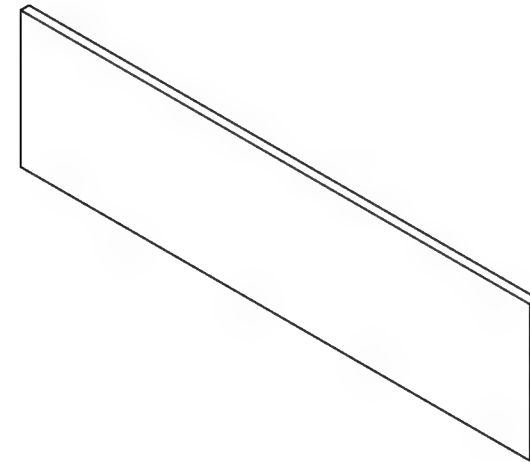
NOTE:
FIT TO WELDMENT.



TITLE		SUPPORT DOLLY, TAILBOOM	
DWG NO.		RB T102012-249	
REV		B	
MAT'L A36/1018/1020 HR		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH SEE -241 WELDMENT		.XXX ± .010 FRACTIONS ± 1/8	
SPEC		.XX ± .03 ANGLES ± 1°	
DRAWN BY: GILBERT		.X ± .1 SURFACES = 125	
CHECKED: RF		1. BREAK ALL SHARP EDGES	
OPPS APPR: FK		.015 x 45° OR .015R	
QA APPR: N/A		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
APPROVED: SAD		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
SCALE 1:4		USED ON MODEL	
DATE 3/13/2014		BELL 212, 214B, 214ST, 412	
SHEET 10 OF 29			

(-249)
AFT CRADLE FACE

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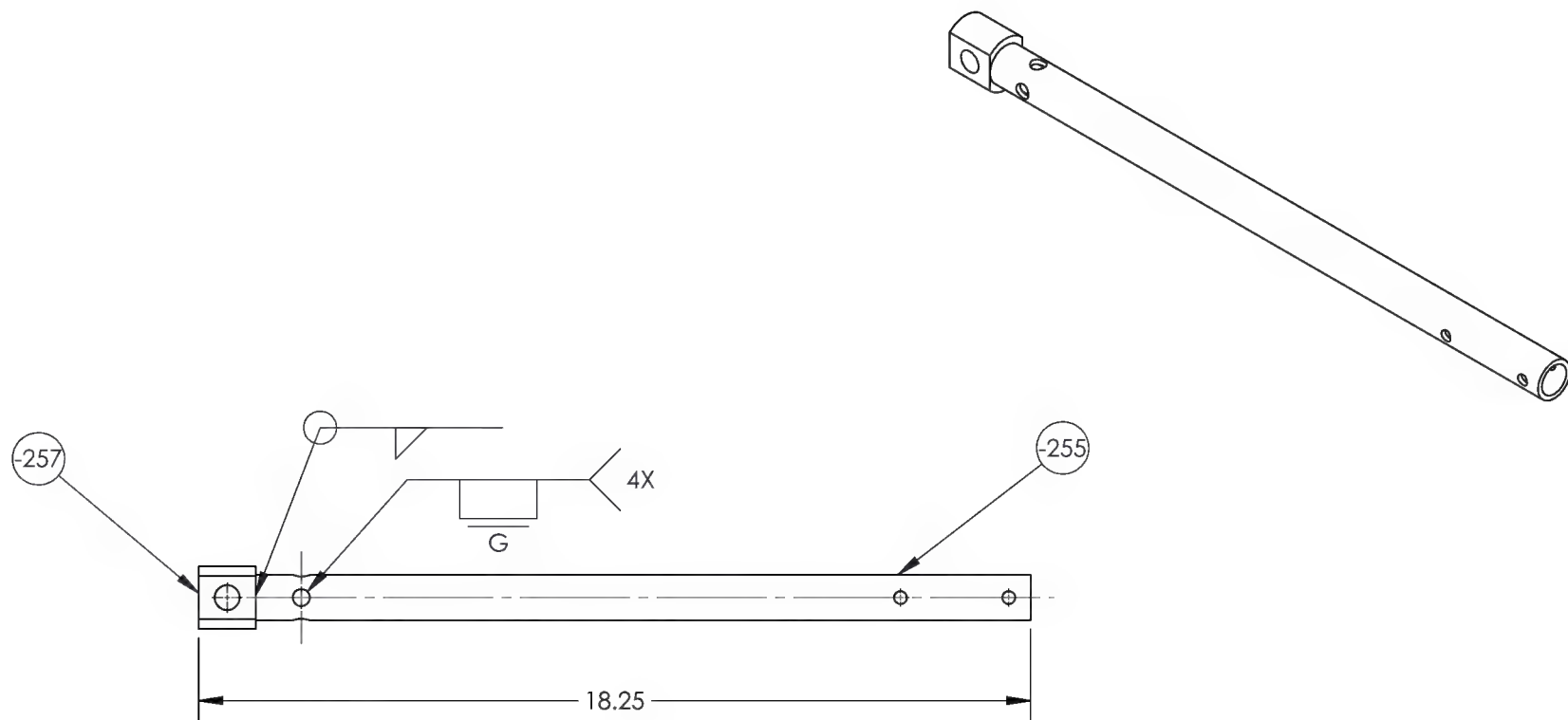
(-251)

AFT CRADLE BOTTOM PLATE



TITLE		SUPPORT DOLLY, TAILBOOM	
DWG NO.		RB T102012-251	
REV		B	
MAT'L A36/1018/1020 HR		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH SEE -241 WELDMENT		.XXX ± .010 FRACTIONS ± 1/8	
SPEC		.XX ± .03 ANGLES ± 1°	
DRAWN BY: GILBERT		.X ± .1 SURFACES = 125	
CHECKED: RF		1. BREAK ALL SHARP EDGES	
OPPS APPR: FK		.015 x 45° OR .015R	
QA APPR: N/A		2. DIMENSIONAL LIMITS APPLY	
APPROVED: SAD		AFTER PLATING	
SCALE 1:2		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE 3/13/2014		USED ON MODEL	
SHEET 11 OF 29		BELL 212, 214B, 214ST, 412	

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(-253)
TOP TUBE WELDMENT



TITLE
SUPPORT DOLLY, TAILBOOM

DWG NO. RB T102012-253

REV
B

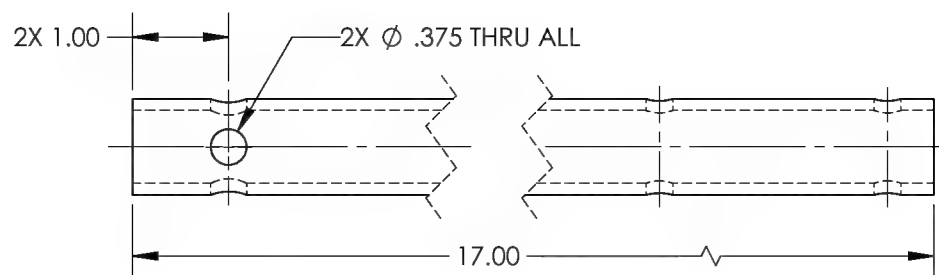
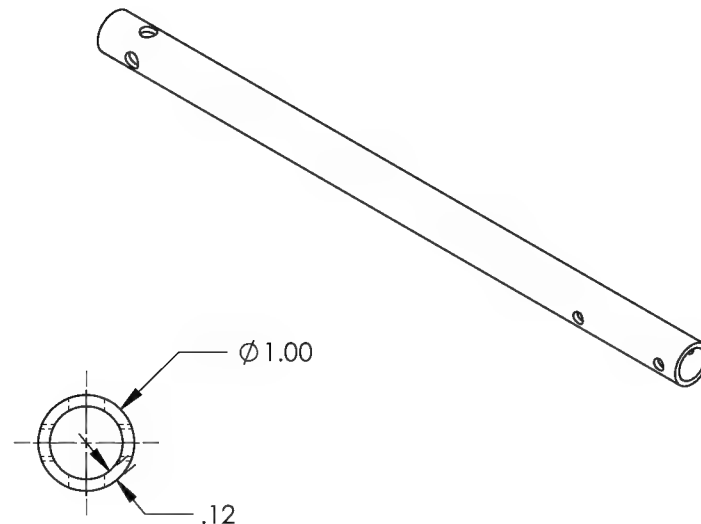
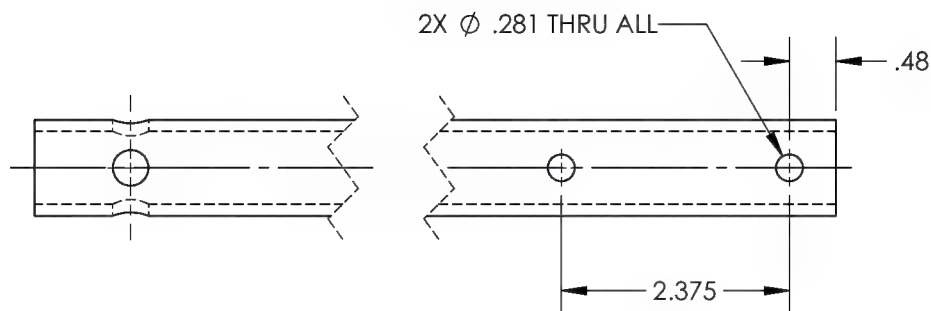
MAT'L
HEAT
TREAT
FINISH POWDER COAT YELLOW
SPEC FED #13538

DRAWN BY: GILBERT
CHECKED: RF
OPPS APPR: FK
QA APPR: N/A
APPROVED: SAD
SCALE 1:4

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .010 FRACTIONS ± 1/8
.XX ± .03 ANGLES ± 1°
.X ± .1 SURFACES = 125°
1. BREAK ALL SHARP EDGES
.015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY
AFTER PLATING
3. INTERPRET DIM AND TOL PER
ASME Y14.5M-2009

USED ON MODEL
BELL 212, 214B, 214ST, 412
DATE 3/13/2014
SHEET 12 OF 29

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(-255)

TOP TUBE



TITLE SUPPORT DOLLY, TAILBOOM

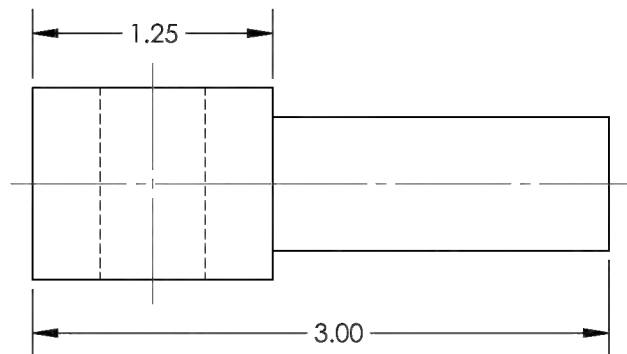
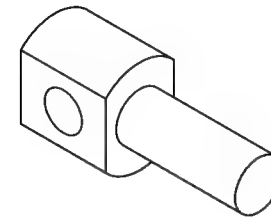
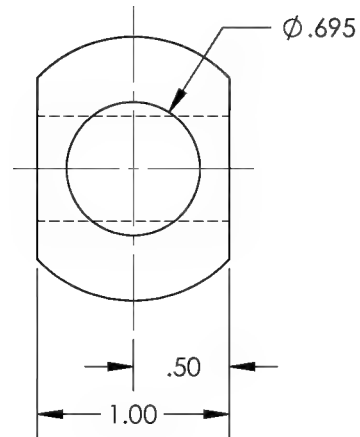
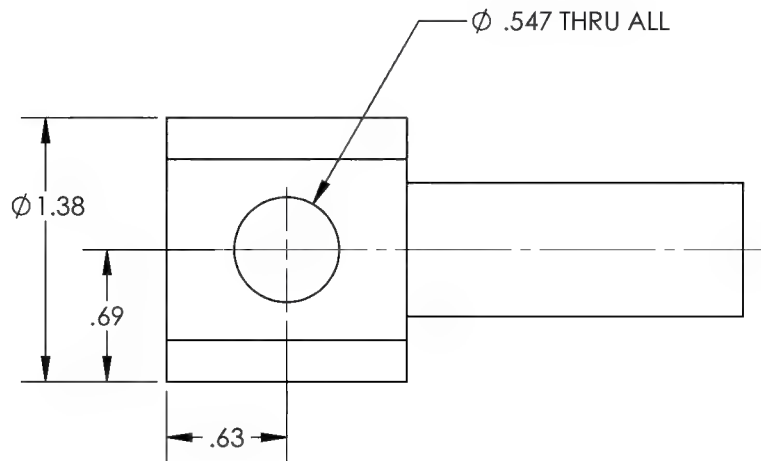
DWG NO. RB T102012-255

REV B

MAT'L	DOM	UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH	SEE -253 WELDMENT	.XXX ± .010	FRACTIONS ± 1/8
SPEC		.XX ± .03	ANGLES ± 1°
		.X ± .1	SURFACES = 125
DRAWN BY:	GILBERT	1. BREAK ALL SHARP EDGES	
CHECKED:	RF	.015 x 45° OR .015R	
OPPS APPR:	FK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
QA APPR:	N/A	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
APPROVED:	SAD	USED ON MODEL	
SCALE	1:2	DATE	3/13/2014
			SHEET 13 OF 29

BELL 212, 214B, 214ST, 412

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(-257)

MOUNT PIN



TITLE

SUPPORT DOLLY, TAILBOOM

DWG NO.

RB T102012-257

REV

B

MAT'L A36/1018/1020 HR

HEAT

TREAT

FINISH SEE -253 WELDMENT

SPEC

DRAWN BY: GILBERT

CHECKED: RF

OPPS APPR: FK

QA APPR: N/A

APPROVED: SAD

SCALE 1:1

UNLESS OTHERWISE SPECIFIED

DIMENSIONS ARE IN INCHES

.XXX ± .005 FRACTIONS ± 1/8

.XX ± .01 ANGLES ± .5°

.X ± .1 SURFACES = 125

1. BREAK ALL SHARP EDGES

.015 x 45° OR .015R

2. DIMENSIONAL LIMITS APPLY

AFTER PLATING

3. INTERPRET DIM AND TOL PER

ASME Y14.5M-2009

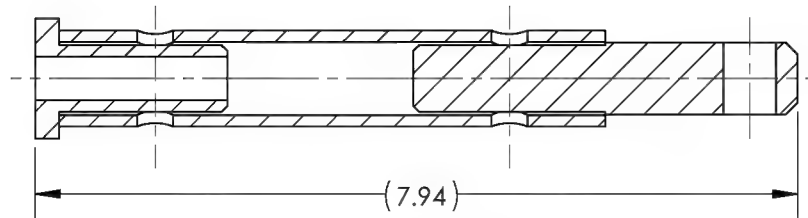
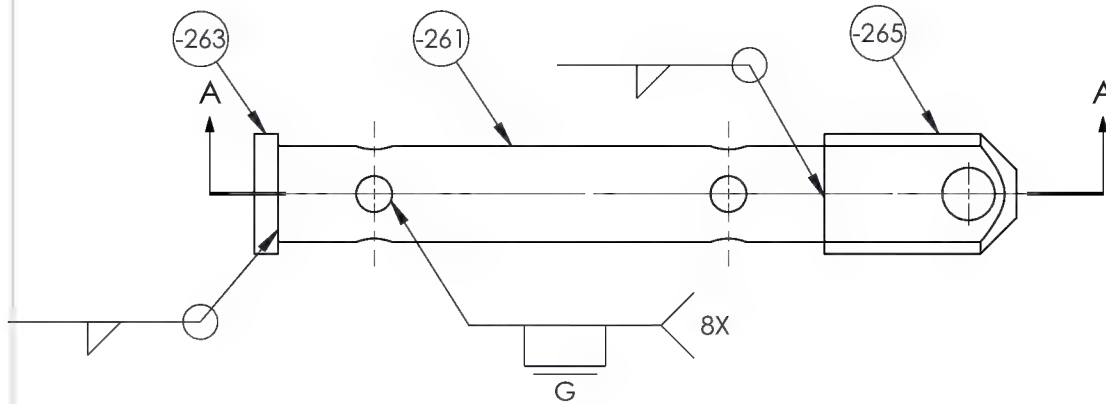
USED ON MODEL

BELL 212, 214B, 214ST, 412

DATE 3/13/2014

SHEET 14 OF 29

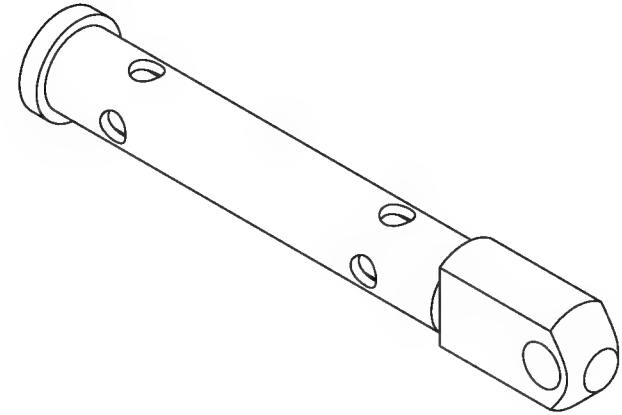
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SECTION A-A

(-259)

LOWER AFT TUBE WELDMENT



TITLE

SUPPORT DOLLY, TAILBOOM

DWG NO.

RB T102012-259

REV
B

MAT'L
HEAT
TREAT
FINISH POWDER COAT YELLOW
SPEC FED #13538

DRAWN BY: GILBERT
CHECKED: RF
OPPS APPR: FK
QA APPR: N/A
APPROVED: SAD

SCALE 1:2

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .010 FRACTIONS ± 1/8
.XX ± .03 ANGLES ± 1°
.X ± .1 SURFACES = 125°

1. BREAK ALL SHARP EDGES
.015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY
AFTER PLATING
3. INTERPRET DIM AND TOL PER
ASME Y14.5M-2009

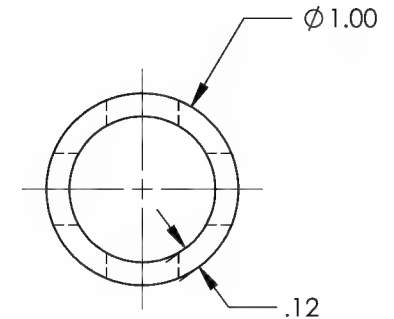
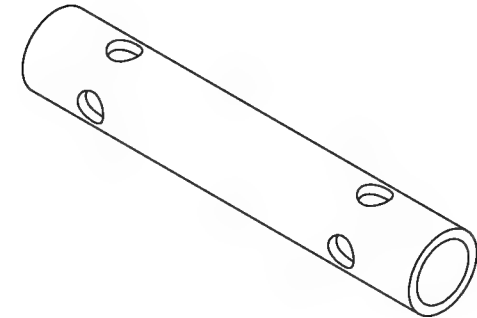
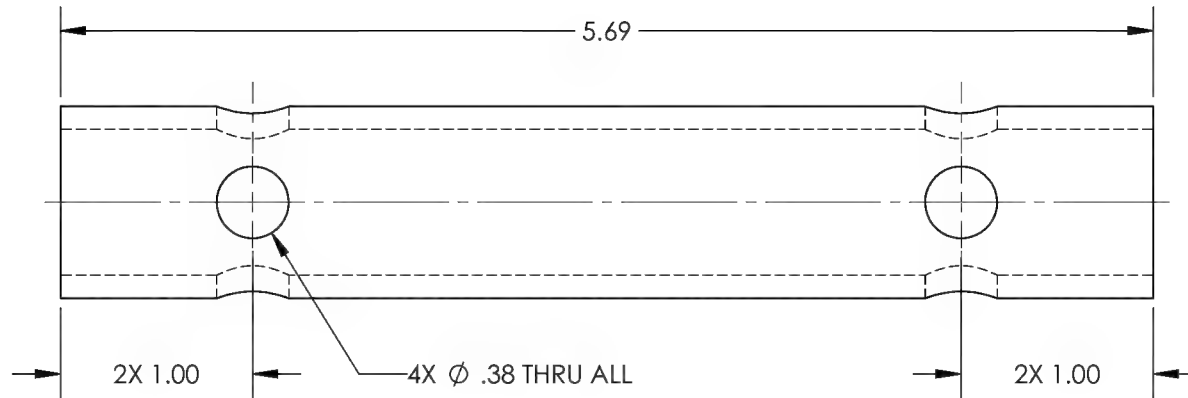
USED ON MODEL

BELL 212, 214B, 214ST, 412

DATE 3/13/2014

SHEET 15 OF 29

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(-261)

LOWER TUBE AFT



TITLE

SUPPORT DOLLY, TAILBOOM

DWG NO.

RB T102012-261

REV
B

MAT'L DOM

HEAT

TREAT

FINISH SEE -259, -267 WELDMENTS

SPEC

DRAWN BY: GILBERT

CHECKED: RF

OPPS APPR: FK

QA APPR: N/A

APPROVED: SAD

SCALE 1:1

UNLESS OTHERWISE SPECIFIED

DIMENSIONS ARE IN INCHES

.XXX \pm .010 FRACTIONS \pm 1/8

.XX \pm .03 ANGLES \pm 1°

.X \pm .1 SURFACES = 125

1. BREAK ALL SHARP EDGES

.015 x 45° OR .015R

2. DIMENSIONAL LIMITS APPLY

AFTER PLATING

3. INTERPRET DIM AND TOL PER

ASME Y14.5M-2009

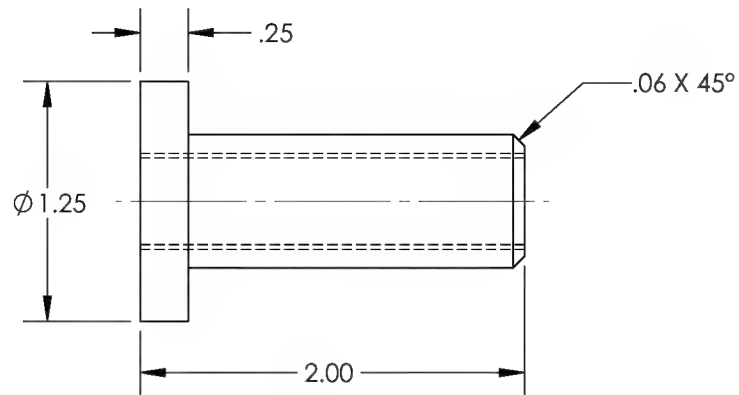
USED ON MODEL

BELL 212, 214B, 214ST, 412

DATE 3/13/2014

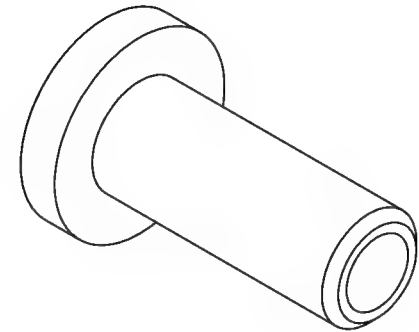
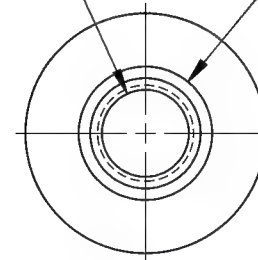
SHEET 16 OF 29

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1/2-20 UNF - 2B THRU ALL

$\varnothing .695$
(S.F. -261)



-263

LOWER TUBE PIN



TITLE

SUPPORT DOLLY, TAILBOOM

DWG NO.

RB T102012-263

REV
B

MAT'L A36/1018/1020 HR

HEAT

TREAT

FINISH SEE -259 WELDMENT

SPEC

DRAWN BY: GILBERT

CHECKED: RF

OPPS APPR: FK

QA APPR: N/A

APPROVED: SAD

SCALE 1:1

UNLESS OTHERWISE SPECIFIED

DIMENSIONS ARE IN INCHES

.XXX ± .010 FRACTIONS ± 1/8

.XX ± .03 ANGLES ± 1°

.X ± .1 SURFACES = 125

1. BREAK ALL SHARP EDGES

.015 x 45° OR .015R

2. DIMENSIONAL LIMITS APPLY

AFTER PLATING

3. INTERPRET DIM AND TOL PER

ASME Y14.5M-2009

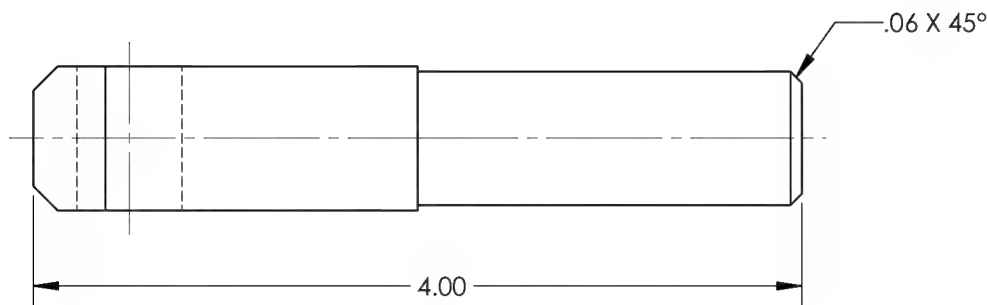
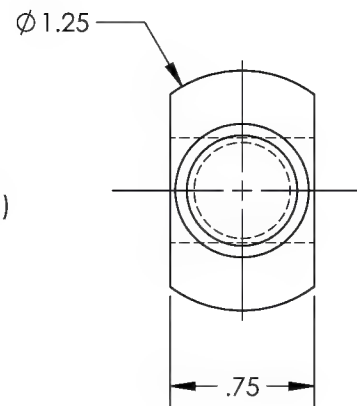
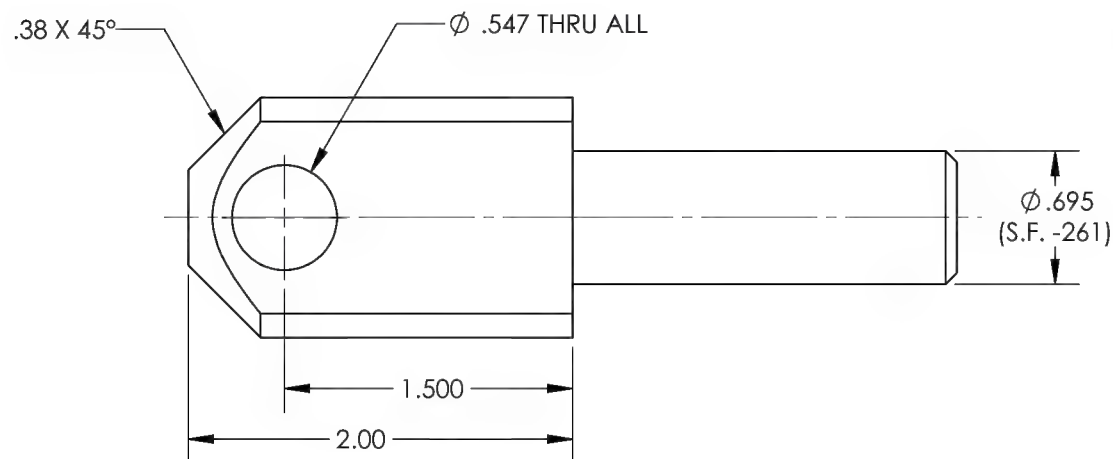
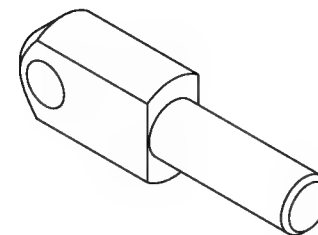
USED ON MODEL

BELL 212, 214B, 214ST, 412

DATE 3/13/2014

SHEET 17 OF 29

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(-265)

LOWER TUBE MOUNT PIN AFT



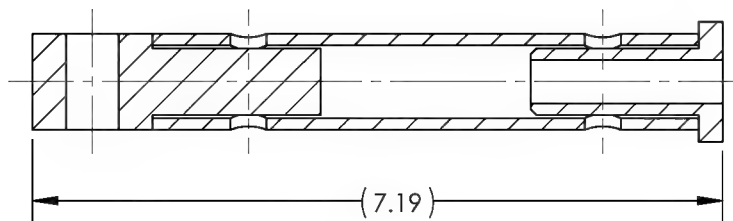
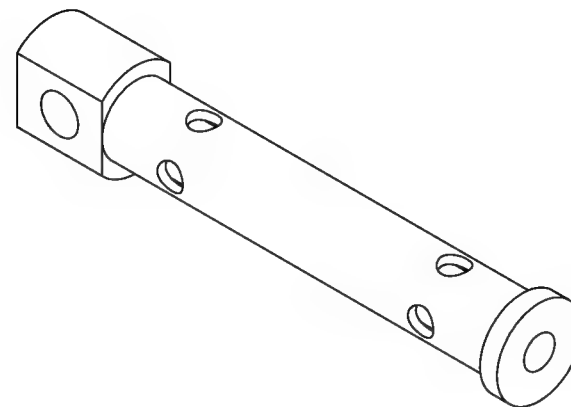
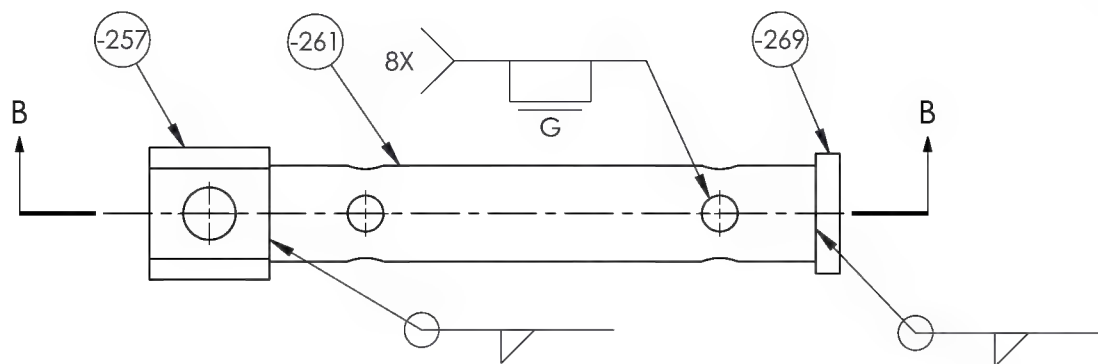
TITLE		SUPPORT DOLLY, TAILBOOM	
DWG NO.		RB T102012-265	
REV		B	
MAT'L		A36/1018/1020 HR	
HEAT TREAT		SEE -259 WELDMENT	
FINISH		SEE -259 WELDMENT	
SPEC		UNLESS OTHERWISE SPECIFIED	
DRAWN BY:		GILBERT	
CHECKED:		RF	
OPPS APPR:		FK	
QA APPR:		N/A	
APPROVED:		SAD	
SCALE		1:1	
DATE		3/13/2014	
SHEET		18 OF 29	

UNLESS OTHERWISE SPECIFIED
 DIMENSIONS ARE IN INCHES
 .XXX \pm .005 FRACTIONS \pm 1/8
 .XX \pm .01 ANGLES \pm .5°
 .X \pm .1 SURFACES = 125°
 1. BREAK ALL SHARP EDGES
 .015 x 45° OR .015R
 2. DIMENSIONAL LIMITS APPLY
 AFTER PLATING
 3. INTERPRET DIM AND TOL PER
 ASME Y14.5M-2009

USED ON MODEL

BELL 212, 214B, 214ST, 412

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SECTION B-B

-267

LOWER FORWARD TUBE WELDMENT



TITLE SUPPORT DOLLY, TAILBOOM

DWG NO. RB T102012-267

REV B

MAT'L
HEAT
TREAT
FINISH POWDER COAT YELLOW

SPEC FED #13538

DRAWN BY: GILBERT

CHECKED: RF

OPPS APPR: FK

QA APPR: N/A

APPROVED: SAD

SCALE 1:2

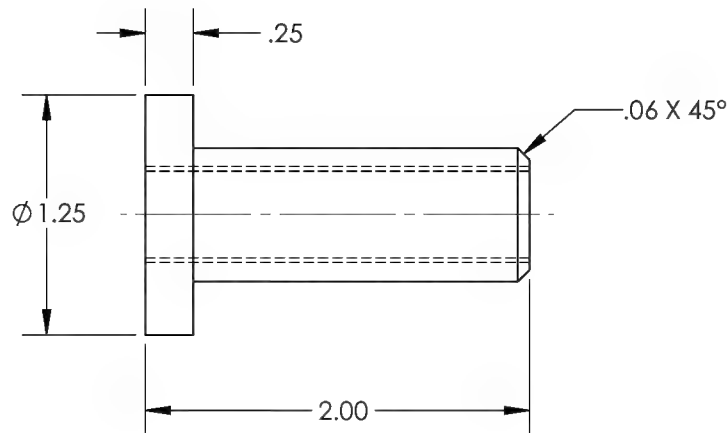
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .010 FRACTIONS ± 1/8
.XX ± .03 ANGLES ± 1°
.X ± .1 SURFACES = 125

1. BREAK ALL SHARP EDGES
.015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY
AFTER PLATING
3. INTERPRET DIM AND TOL PER
ASME Y14.5M-2009

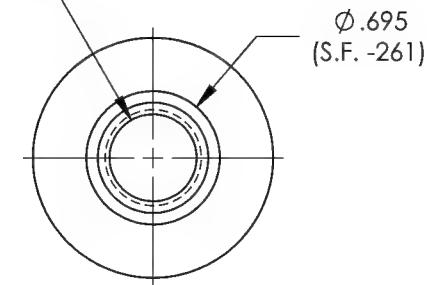
USED ON MODEL

BELL 212, 214B, 214ST, 412

DATE 3/13/2014 SHEET 19 OF 29



1/2-20 UNF - 2B, LH THRU ALL

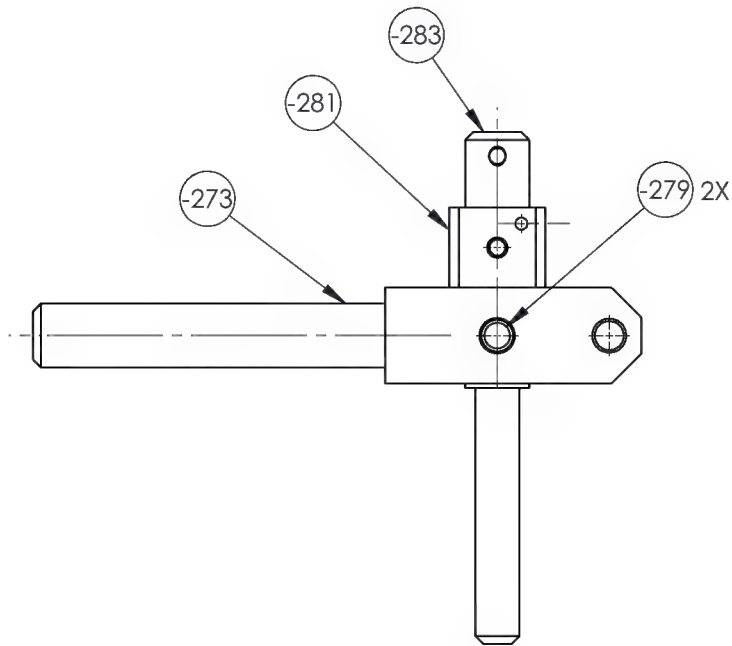


(-269)
LOWER TUBE LH PIN



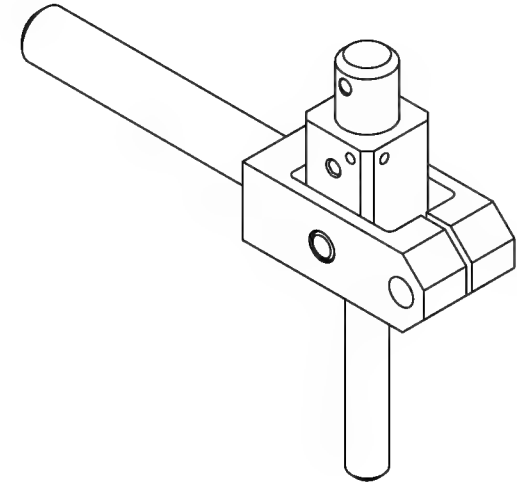
TITLE		SUPPORT DOLLY, TAILBOOM	
DWG NO.		RB T102012-269	
REV		B	
MAT'L A36/1018/1020 HR		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH SEE -257 WELDMENT		.XXX ± .010 FRACTIONS ± 1/8	
SPEC		.XX ± .03 ANGLES ± 1°	
DRAWN BY: GILBERT		.X ± .1 SURFACES = 125	
CHECKED: RF		1. BREAK ALL SHARP EDGES	
OPPS APPR: FK		.015 x 45° OR .015R	
QA APPR: N/A		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
APPROVED: SAD		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
SCALE 1:1		USED ON MODEL	
DATE 3/13/2014		BELL 212, 214B, 214ST, 412	
SHEET 20 OF 29			

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-271

AFT ADJUSTABLE CLAMP ASSEMBLY

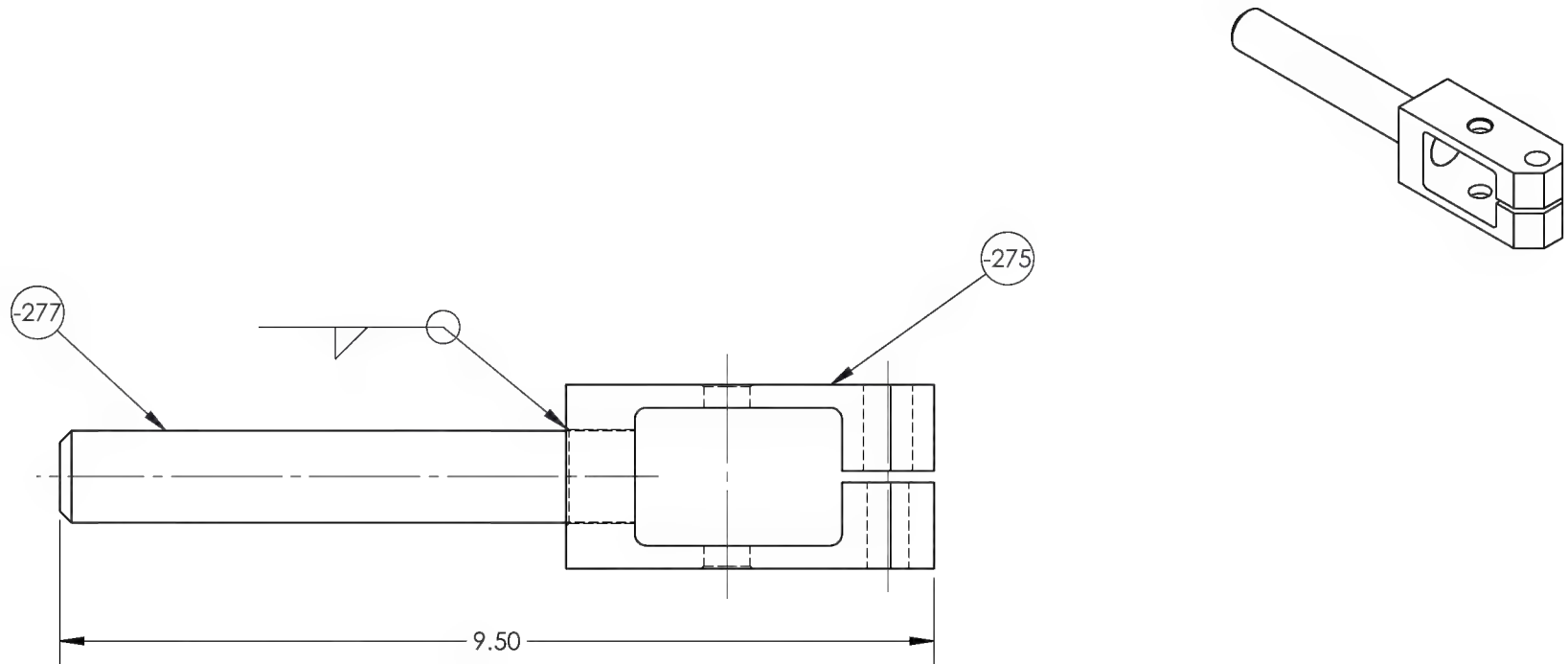


NOTE:
MUST PIVOT FREELY.



TITLE		SUPPORT DOLLY, TAILBOOM	
DWG NO.		RB T102012-271	
		REV B	
MAT'L		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH POWDER COAT YELLOW		.XXX ± .005 FRACTIONS ± 1/8	
SPEC FED #13538		.XX ± .01 ANGLES ± 5°	
DRAWN BY: GILBERT		.X ± .1 SURFACES = 125	
CHECKED: RF		1. BREAK ALL SHARP EDGES	
OPPS APPR: FK		.015 x 45° OR .015R	
QA APPR: N/A		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
APPROVED: SAD		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
SCALE 1:3		USED ON MODEL	
DATE 3/13/2014		BELL 212, 214B, 214ST, 412	
		SHEET 21 OF 29	

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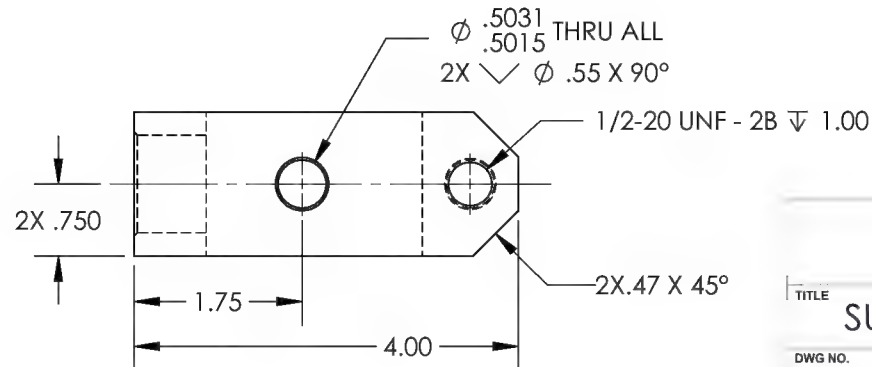
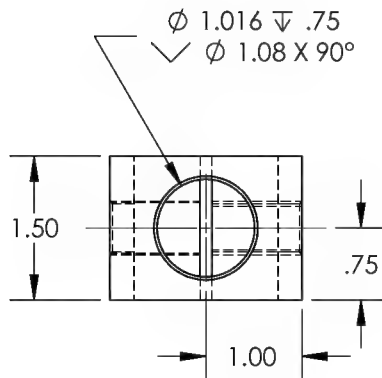
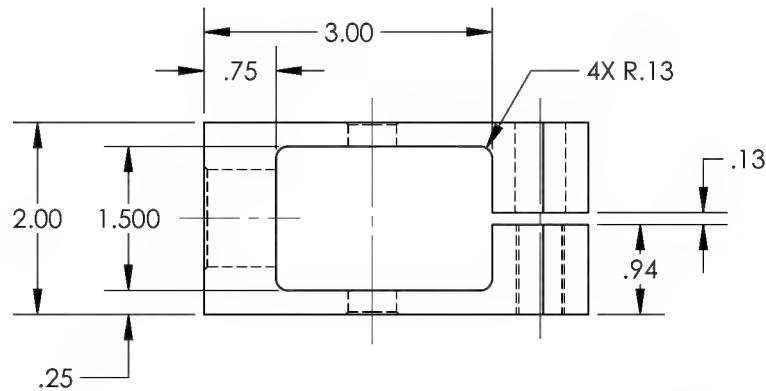
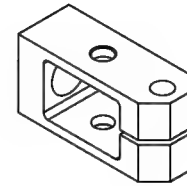
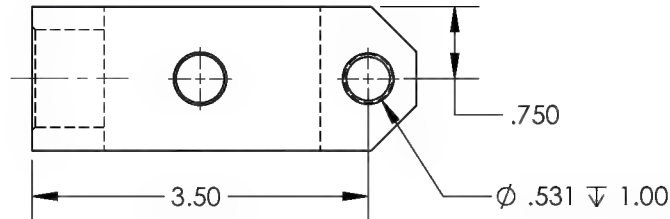


-273
AFT CLAMP WELDMENT



TITLE		SUPPORT DOLLY, TAILBOOM	
DWG NO.		RB T102012-273	
REV		B	
MAT'L		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH	ZINC PLATE	.XXX ± .010 FRACTIONS ± 1/8	
SPEC	ASTM B633 TYPE I SC 2	.XX ± .03 ANGLES ± 1°	
DRAWN BY:	GILBERT	.X ± .1 SURFACES = 125	
CHECKED:	RF	1. BREAK ALL SHARP EDGES	
OPPS APPR:	FK	.015 x 45° OR .015R	
QA APPR:	N/A	2. DIMENSIONAL LIMITS APPLY	
APPROVED:	SAD	AFTER PLATING	
SCALE	1:2	3. INTERPRET DIM AND TOL PER	
DATE	3/13/2014	ASME Y14.5M-2009	
		USED ON MODEL	
		BELL 212, 214B, 214ST, 412	
		SHEET 22 OF 29	

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-275

CLAMP



TITLE SUPPORT DOLLY, TAILBOOM

DWG NO. RB T102012-275

REV B

MAT'L A36/1018/1020 HR

HEAT TREAT SEE -273 WELDMENT

SPEC

DRAWN BY: GILBERT

CHECKED: RF

OPPS APPR: FK

QA APPR: N/A

APPROVED: SAD

SCALE 1:2

UNLESS OTHERWISE SPECIFIED

DIMENSIONS ARE IN INCHES

.XXX ± .005 FRACTIONS ± 1/8

.XX ± .01 ANGLES ± 5°

.X ± .1 SURFACES = 125

1. BREAK ALL SHARP EDGES

.015 x 45° OR .015R

2. DIMENSIONAL LIMITS APPLY

AFTER PLATING

3. INTERPRET DIM AND TOL PER

ASME Y14.5M-2009

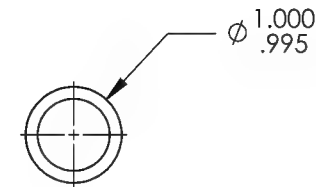
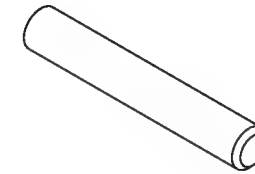
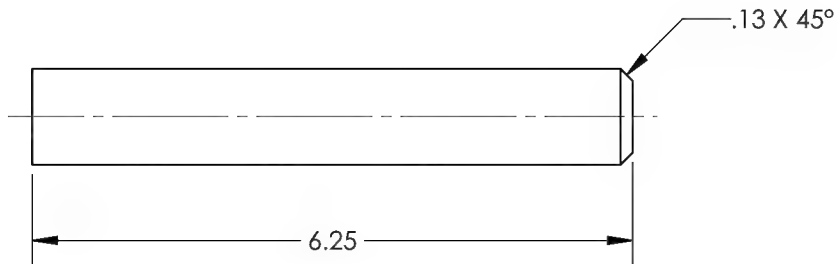
USED ON MODEL

BELL 212, 214B, 214ST, 412

DATE 3/13/2014

SHEET 23 OF 29

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(-277)

CLAMP PIN



TITLE

SUPPORT DOLLY TAILBOOM

DWG NO.

RB T102012-277

REV
B

MAT'L 4140/4142

HEAT

TREAT

FINISH SEE -273 WELDMENT

SPEC

DRAWN BY: GILBERT

CHECKED: RF

OPPS APPR: FK

QA APPR: N/A

APPROVED: SAD

SCALE 1:2

UNLESS OTHERWISE SPECIFIED

DIMENSIONS ARE IN INCHES

.XXX \pm .005 FRACTIONS \pm 1/8

.XX \pm .01 ANGLES \pm .5°

.X \pm .1 SURFACES = 125

1. BREAK ALL SHARP EDGES

.015 x 45° OR .015R

2. DIMENSIONAL LIMITS APPLY

AFTER PLATING

3. INTERPRET DIM AND TOL PER

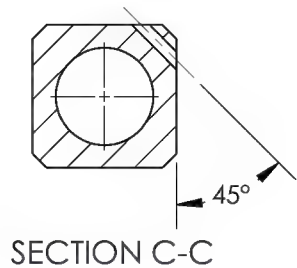
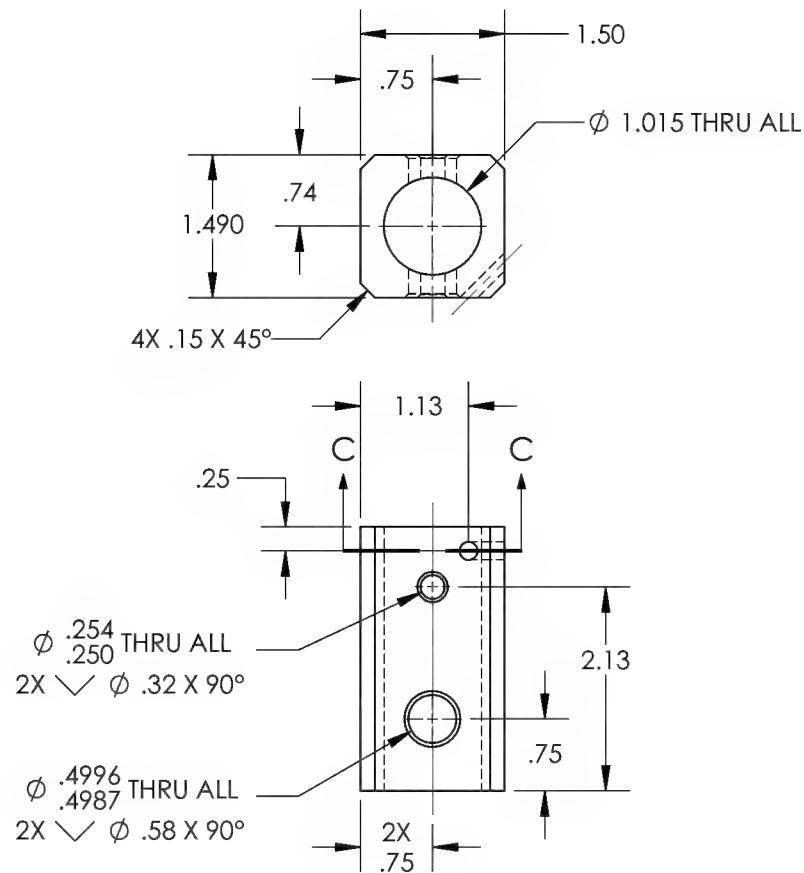
ASME Y14.5M-2009

USED ON MODEL

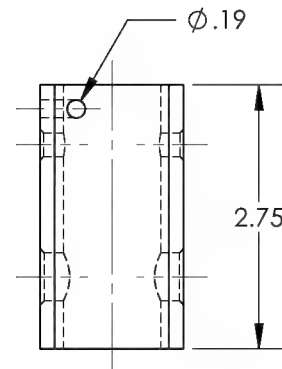
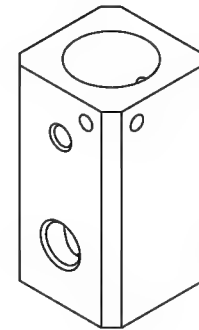
BELL 212, 214B, 214ST, 412

DATE 3/13/2014 SHEET 24 OF 29

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(-281)
BLOCK

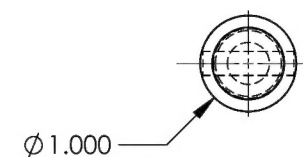
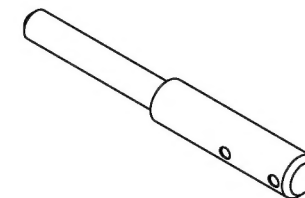
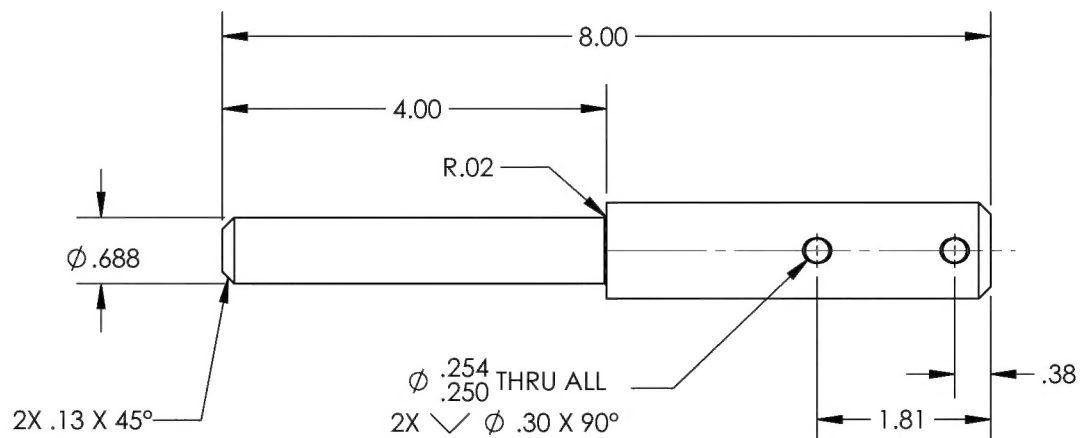


TITLE		SUPPORT DOLLY, TAILBOOM	
DWG NO.		RB T102012-281	
REV		B	
MAT'L		A36/1018/1020 HR	
HEAT TREAT		ZINC PLATE	
FINISH		ASTM B633 TYPE I SC 2	
SPEC		DRAWN BY: GILBERT	
CHECKED:		RF	
OPPS APPR:		FK	
QA APPR:		N/A	
APPROVED:		SAD	
SCALE		1:2	
DATE		3/13/2014	
SHEET		25 OF 29	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX \pm .005 FRACTIONS \pm 1/8
.XX \pm .01 ANGLES \pm .5°
.X \pm .1 SURFACES = 125°
1. BREAK ALL SHARP EDGES
.015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY
AFTER PLATING
3. INTERPRET DIM AND TOL PER
ASME Y14.5M-2009
USED ON MODEL

BELL 212, 214B, 214ST, 412

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-283

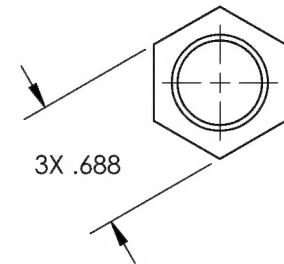
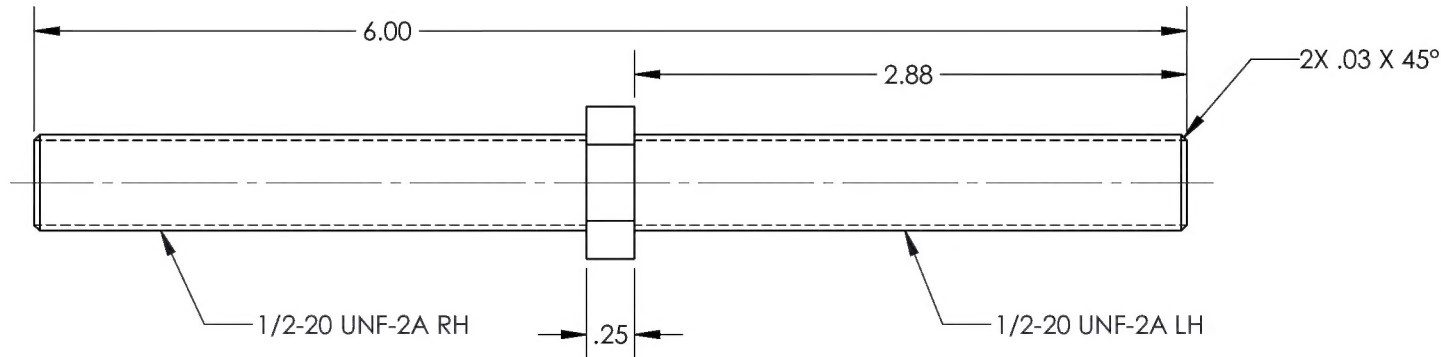
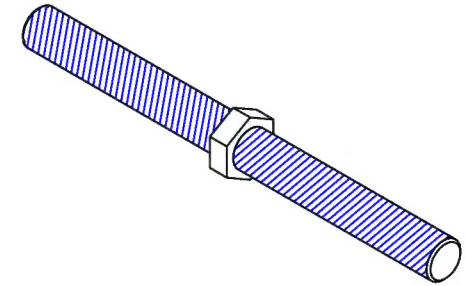
B

BLOCK PIN



TITLE		SUPPORT DOLLY, TAILBOOM	
DWG NO.		RB T102012-283	
REV		B	
MAT'L 4140/4142		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT RC 28-34		DIMENSIONS ARE IN INCHES	
FINISH ZINC PLATE		.XXX ± .005 FRACTIONS ± 1/8	
SPEC ASTM B633 TYPE I SC 2		.XX ± .01 ANGLES ± 5°	
DRAWN BY: GILBERT		.X ± .1 SURFACES = 125	
CHECKED: RF		1. BREAK ALL SHARP EDGES	
OPPS APPR: FK		.015 x 45° OR .015R	
QA APPR: N/A		2. DIMENSIONAL LIMITS APPLY	
APPROVED: SAD		AFTER PLATING	
SCALE 1:2		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE 3/13/2014		USED ON MODEL	
SHEET 26 OF 29		BELL 212, 214B, 214ST, 412	

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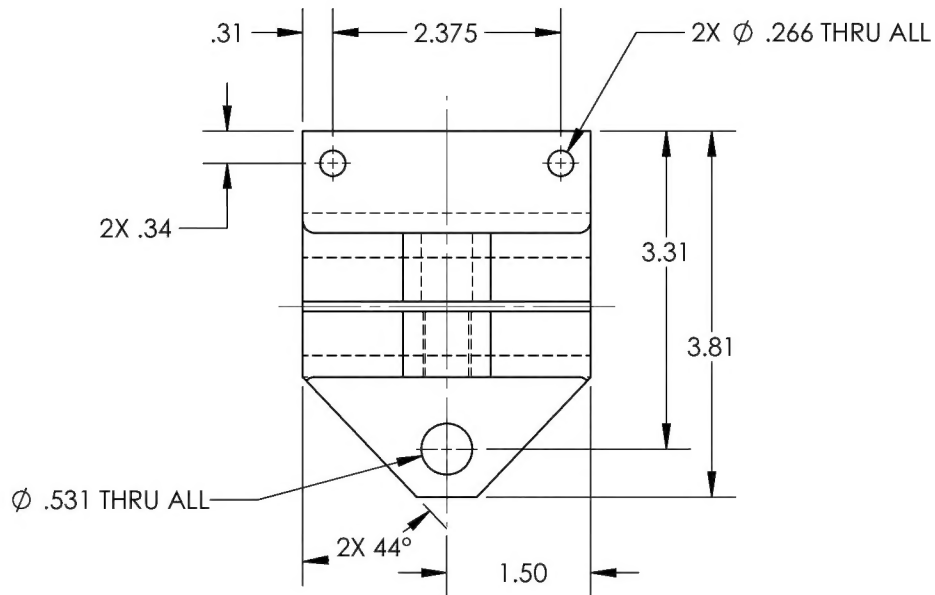
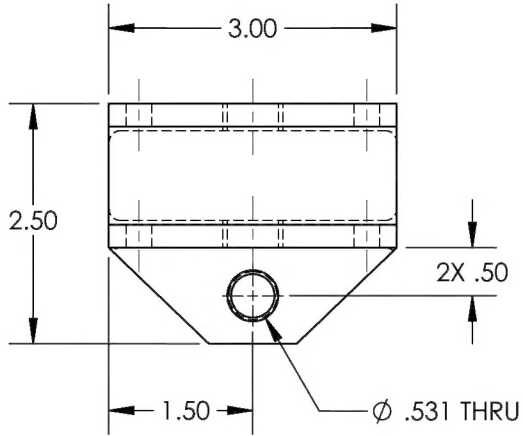
(-285)

ADJUSTABLE CONNECTOR

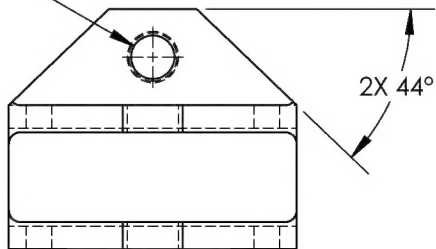


TITLE		SUPPORT DOLLY, TAILBOOM	
DWG NO.	RB T102012-285		REV B
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED		
HEAT RC 28-34	DIMENSIONS ARE IN INCHES		
FINISH CAD PLATE YELLOW	.XXX ± .005 FRACTIONS ± 1/8		
SPEC QQ-P-416F, TYPE II, CLASS II	.XX ± .01 ANGLES ± 5°		
DRAWN BY: GILBERT	.X ± .1 SURFACES = 125		
CHECKED: RF	1. BREAK ALL SHARP EDGES		
OPPS APPR: FK	.015 x 45° OR .015R		
QA APPR: N/A	2. DIMENSIONAL LIMITS APPLY		
APPROVED: SAD	AFTER PLATING		
SCALE 1:1	DATE 3/13/2014	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
		USED ON MODEL	
		BELL 212, 214B, 214ST, 412	
		SHEET 27 OF 29	

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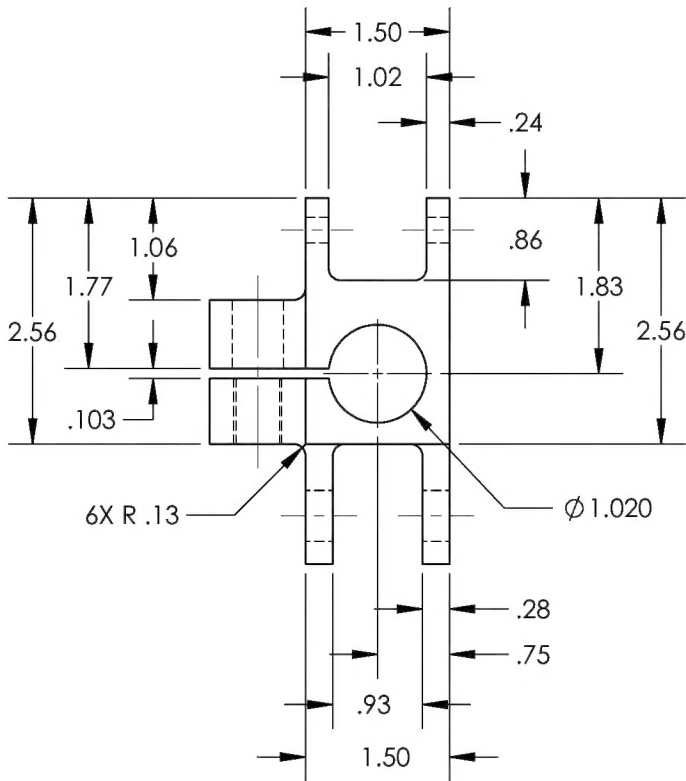
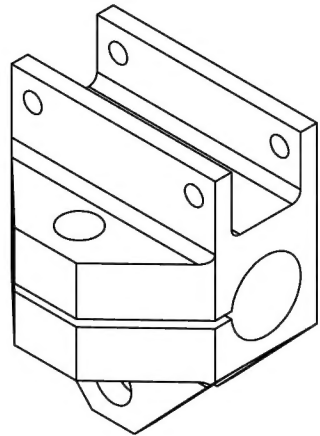



1/2-20 UNF - 2B THRU ALL



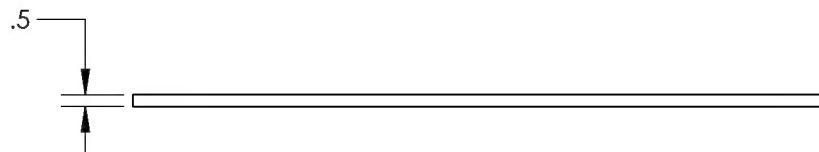
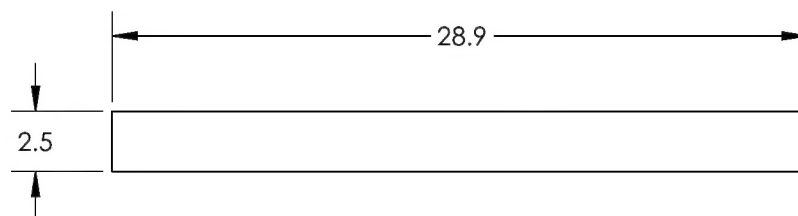
-287

TOP TUBE CLAMP



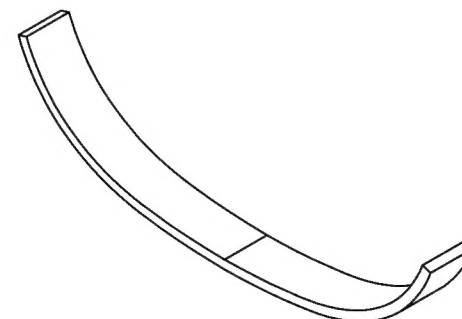
			
TITLE SUPPORT DOLLY, TAILBOOM			
DWG NO. RB T102012-287			REV B
MAT'L A36/1018/1020 HR		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT		.XXX ± .005 FRACTIONS ± 1/8	
FINISH ZINC PLATE		.XX ± .01 ANGLES ± 5°	
SPEC ASTM B633 TYPE I SC 2		.X ± .1 SURFACES = 125 ✓	
DRAWN BY: GILBERT		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED: RF		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR: FK		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR: N/A		USED ON MODEL	
APPROVED: SAD		BELL 212, 214B, 214ST, 412	
SCALE 1:2	DATE 3/13/2014	SHEET 28 OF 29	

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REAR CRADLE PAD



TITLE		SUPPORT DOLLY TAILBOOM	
DWG NO.		RB T102012-305	
MAT'L 17124		UNLESS OTHERWISE SPECIFIED	
HEAT		DIMENSIONS ARE IN INCHES	
TREAT		XXX ± .010 FRACTIONS ± 1/8	
FINISH		.XX ± .03 ANGLES ± 1°	
SPEC		.X ± .1 SURFACES = 125	
DRAWN BY: GILBERT		1. BREAK ALL SHARP EDGES	
CHECKED: RF		.015 x 45° OR .015R	
OPPS APPR: FK		2. DIMENSIONAL LIMITS APPLY	
QA APPR: N/A		AFTER PLATING	
APPROVED: SAD		3. INTERPRET DIM AND TOL PER	
SCALE 1:8		ASME Y14.5M-2009	
DATE 3/13/2014		USED ON MODEL	
SHEET 29 OF 29		BELL 212, 214B, 214ST, 412	

REV
B